



Est. 1982

THERMALLY BROKEN WINDOWS AND DOORS

OS2 40

TECHNICAL
CATALOG

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Sistema integrato di profili, accessori e guarnizioni con sezione a vista da 47 mm (nodo laterale) e 62 mm (nodo centrale), idoneo per la realizzazione di porte e finestre ad 1 o 2 ante, rettangolari, sagomate o ad arco, con o senza fissi laterali, inferiori o superiori. Sono previsti inoltre profili per la suddivisione delle specchiature vetrate, sia integrali che applicati al vetro, con sezioni in vista da 15 mm.

I **profili** componenti il sistema sono ottenuti tramite profilatura a freddo di nastri in acciaio decapato, dello spessore nominale di 20/10 mm, chiusi mediante saldatura in continuo ad alta frequenza. I profili complementari al sistema sono ottenuti tramite pressopiegatura di lamiere in acciaio decapato dello spessore nominale di 15/10 mm.

La **costruzione dei telai** prevede l'unione tra i profili tramite saldatura in continuo delle sezioni in contatto. Il sistema permette di alloggiare pannelature cieche o trasparenti con spessore massimo di 26 mm.

Caratteristiche del sistema:

Sormonto interno ed esterno delle ante;
Sistema di doppia guarnizione a giunto chiuso;
Cerniere ad avvitare o a saldare;
Kit serrature;
Chiusura inferiore tramite guarnizione automatica a ghigliottina, guarnizione a pinna o sistema di spazzolini.

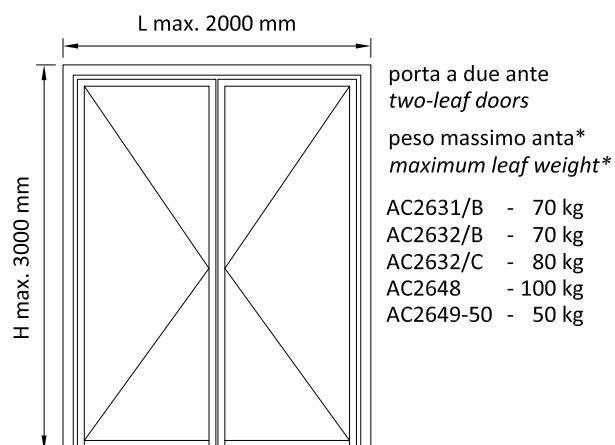
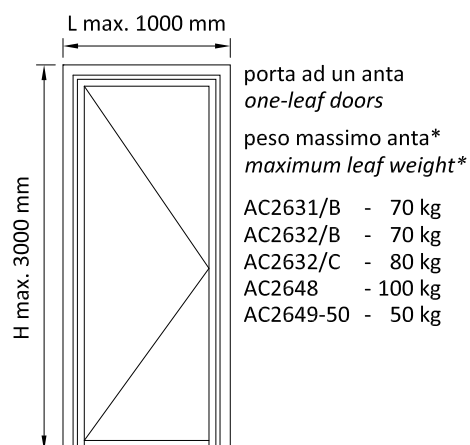
Integrated system of profiles, accessories and gaskets with visible sections from 47 mm (lateral section) and 62 mm (meeting style) for manufacturing rectangular, trapezoidal and arched shaped single or double casement windows and doors, with or without fixed lights. Available also dedicated true and simulated light dividers with visible section down to 15 mm.

The profiles of the system are made by cold-rolling of pickled steel coils, with nominal thickness of 20/10 mm, closed by continuous high frequency welding. Profiles complementary to the system are made by press-bending of pickled steel sheets with nominal thickness of 15/10 mm.

The assembly of the frames involves the welding of the profiles in continuous along the joining lines. The system allows to fit blind or transparent panels with a maximum thickness of 26 mm.

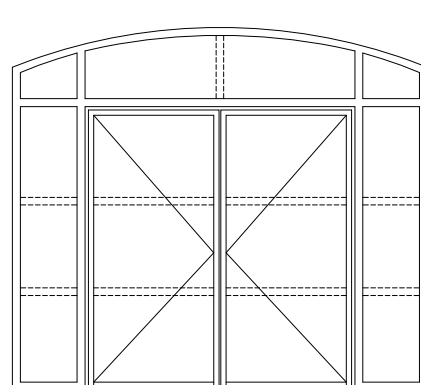
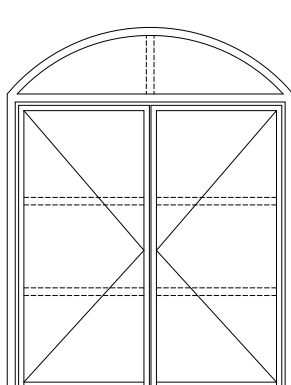
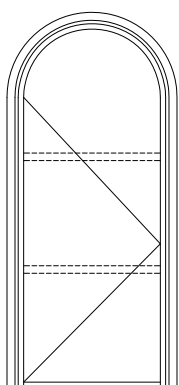
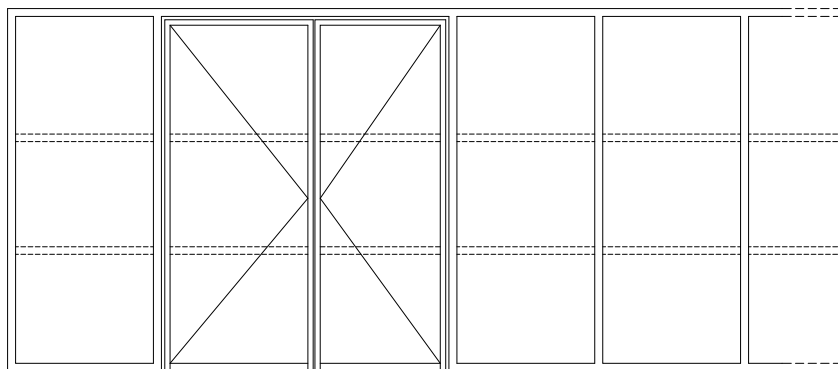
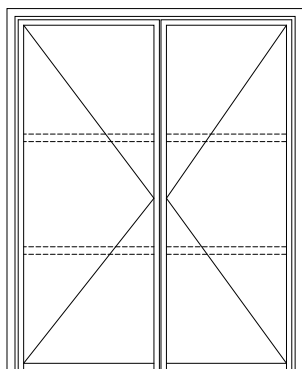
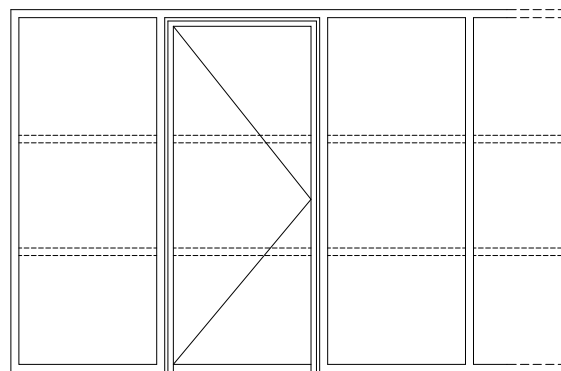
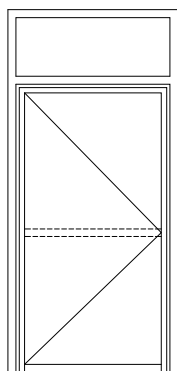
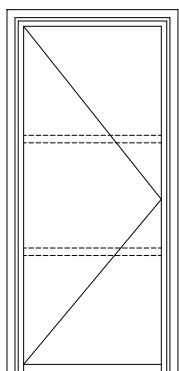
System features:

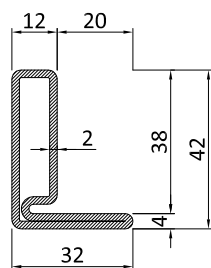
Rebated sashes in and outside;
Two-level gasket system;
Welded or screwed-on hinges;
Locking kits;
Bottom sealing with automatic drop-down system, flipper gasket or brush system.

Limiti dimensionali - Maximum dimension

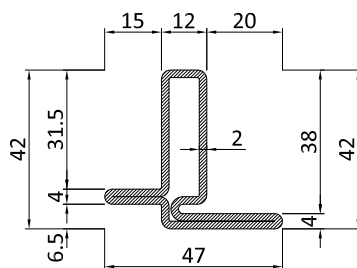
* cerniera aggiuntiva per H serramento > 2300 mm

* additional hinge for doors with height > 2300 mm

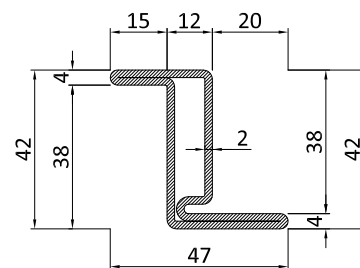
Esempi tipologie realizzabili - Types of door



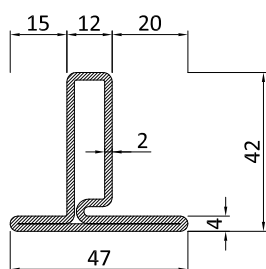
PR2461



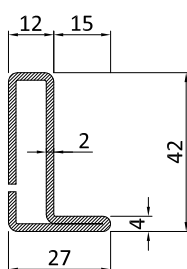
PR2462



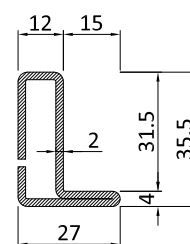
PR2463



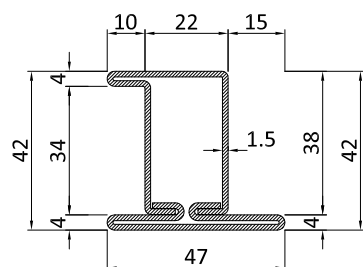
PR2482



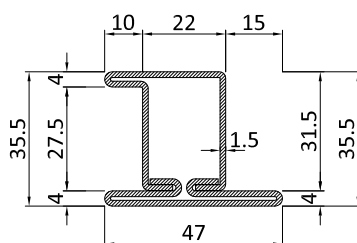
PR2451



PR2471

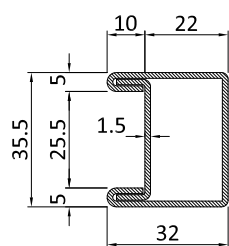


PR2455

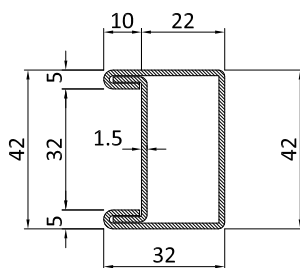


PR2474

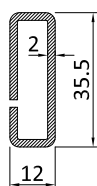
Profilo / Profile n°	P Kg/m	A m ² /m	Jx cm ⁴	Jy cm ⁴	L m	Profilo / Profile n°	P Kg/m	A m ² /m	Jx cm ⁴	Jy cm ⁴	L m
PR2461	2,31	0,16	-	-	6,0	PR2471	1,76	0,12	-	-	4,0
PR2462	2,65	0,18	-	-	6,0	PR2455	2,68	0,20	-	-	4,0
PR2463	2,67	0,19	-	-	6,0	PR2474	2,53	0,19	-	-	4,0
PR2482	2,67	0,19	-	-	6,0						
PR2451	1,95	0,13	-	-	4,0						



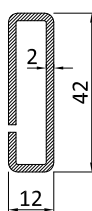
PR2424



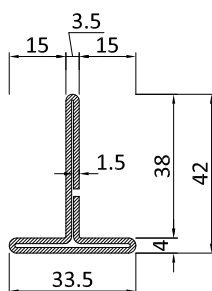
PR2425



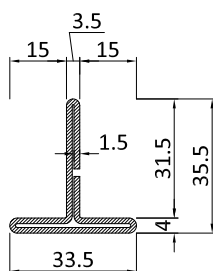
PR2430



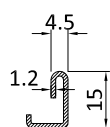
PR2431



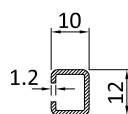
PR2454



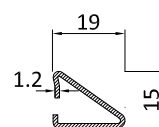
PR2464



PR2415

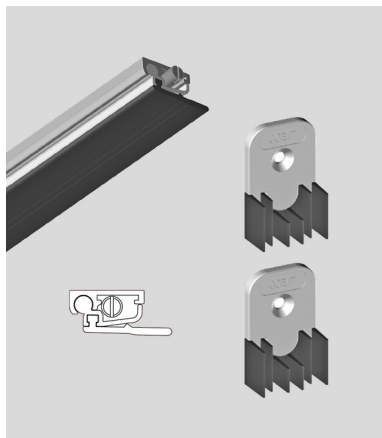


PR2416



PR2429

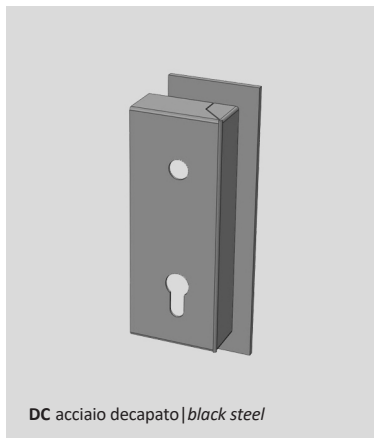
Profilo / Profile n°	P Kg/m	A m ² /m	Jx cm ⁴	Jy cm ⁴	L m	Profilo / Profile n°	P Kg/m	A m ² /m	Jx cm ⁴	Jy cm ⁴	L m
PR2424	1,80	0,16	-	-	4,0	PR2464	1,46	0,13			4,0
PR2425	1,94	0,15	-	-	4,0	PR2415	0,44	0,04			6,0
PR2430	1,35	0,09	-	-	4,0	PR2416	0,41	0,04			6,0
PR2431	1,55	0,10	-	-	4,0	PR2429	0,62	0,05			6,0
PR2454	1,61	0,14			4,0						

**AC 2436/-**

Guarnizione automatica di tenuta sotto porta

Automatic bottom seal

AC2436/Z lunghezza/length 315 - 430 mm
 AC2436/A lunghezza/length 380 - 530 mm
 AC2436/B lunghezza/length 480 - 630 mm
 AC2436/C lunghezza/length 580 - 730 mm
 AC2436/D lunghezza/length 680 - 830 mm
 AC2436/E lunghezza/length 780 - 930 mm
 AC2436/F lunghezza/length 880 - 1030 mm
 AC2436/G lunghezza/length 980 - 1130 mm

**AC 2496**

Scatola copri serratura per anta con singolo fermavetro
 Destra

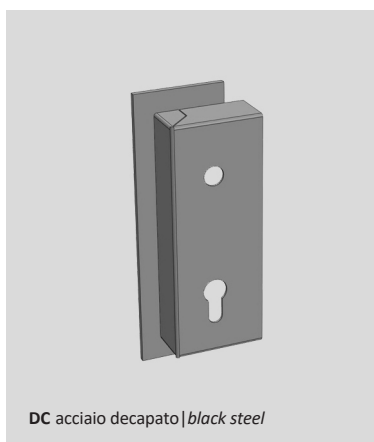
RH lock cover box for leaf with single glazing bead

DC acciaio decapato | black steel

**AC 2440**

Catenaccio 2^a anta a incasso

Second leaf flush bolt for doors

**AC 2497**

Scatola copri serratura per anta con singolo fermavetro
 Sinistra

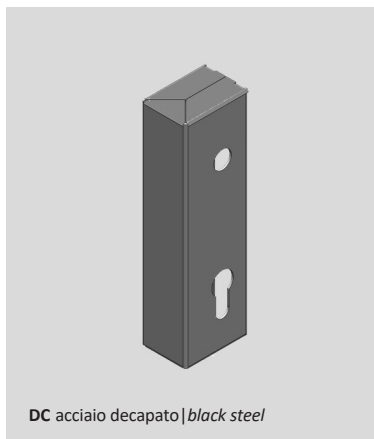
LH lock cover box for leaf with single glazing bead

DC acciaio decapato | black steel

**AC 2493**

Serratura cilindro europeo con incontro magnetico E35 per anta con doppio fermavetro

Euro cylinder lock with magnetic strike E35 for leaf with double glazing beads

**AC 2498**

Scatola copri serratura per anta con doppio fermavetro

Lock cover box for leaf with double glazing beads

DC acciaio decapato | black steel

**AC 2494**

Serratura cilindro europeo con incontro magnetico E50 per anta con singolo fermavetro

Euro cylinder lock with magnetic strike E50 for leaf with single glazing bead

**AC 2621GB**

Catenaccio 2^a anta per porta
 L = 220 mm

*Second leaf flush bolt for doors
 L = 220 mm*

**AC 2621GC**

Catenaccio 2^a anta per porta
L = 650 mm

Second leaf flush bolt for doors
L = 650 mm

**AC 2632/C**

Cerniera registrabile a due ali
in acciaio zincato a saldare | Ø 16
Peso max anta 80 kg

*Adjustable weld-on hinge
in galvanised steel | Ø 16
Max leaf weight 80 kg*

**AC 2631/A**

Cerniera a due ali in acciaio
zincato a saldare | Ø 10
Peso max anta 40 kg

*Weld-on hinge in galvanised
steel | Ø 10
Max leaf weight 40 kg*

**AC 2648**

Cerniera a tre ali da avvitare
su PR2463 (apertura interna)
su PR2462 (apertura esterna)
Peso max anta 100 kg

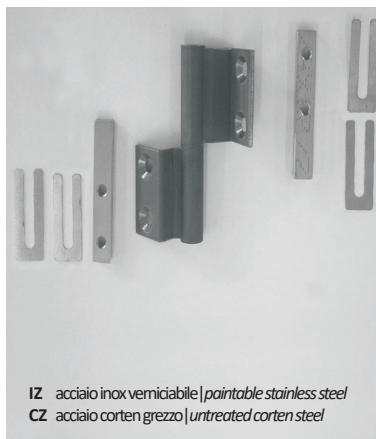
*Three-wing screw-on hinge
on PR2463 (inward opening)
on PR2462 (outward opening)
Max leaf weight 100 kg*

GZ acciaio zincato
galvanized steel
CZ acciaio corten
corten steel

**AC 2631/B**

Cerniera a due ali in acciaio
zincato a saldare | Ø 13
Peso max anta 70 kg

*Weld-on hinge in galvanised
steel | Ø 13
Max leaf weight 70 kg*

**AC 2649.xx.IDES**

Cerniera a due ali da avvitare
Sx su PR2463 (apertura interna)
Dx su PR2462 (apertura esterna)
Peso max anta 50 kg

*Two-wing screw-on hinge
LH on PR2463 (inward opening)
RH on PR2462 (outward opening)
Max leaf weight 50 kg*

IZ acciaio inox verniciabile | paintable stainless steel
CZ acciaio corten grezzo | untreated corten steel

**AC 2632/B**

Cerniera registrabile a due ali
in acciaio zincato a saldare | Ø 13
Peso max anta 70 kg

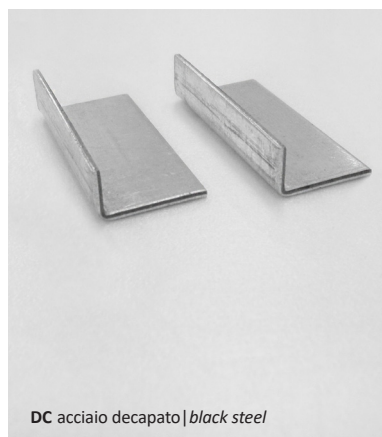
*Adjustable weld-on hinge
in galvanised steel | Ø 13
Max leaf weight 70 kg*

**AC 2650.xx.ISED**

Cerniera a due ali da avvitare
Dx su PR2463 (apertura interna)
Sx su PR2462 (apertura esterna)
Peso max anta 50 kg

*Two-wing screw-on hinge
RH on PR2463 (inward opening)
LH on PR2462 (outward opening)
Max leaf weight 50 kg*

IZ acciaio inox verniciabile | paintable stainless steel
CZ acciaio corten grezzo | untreated corten steel

**AC 2653**

Kit fondini per profili
PR2462 - PR2463

*Fittings kit for profiles
PR2462 - PR2463*

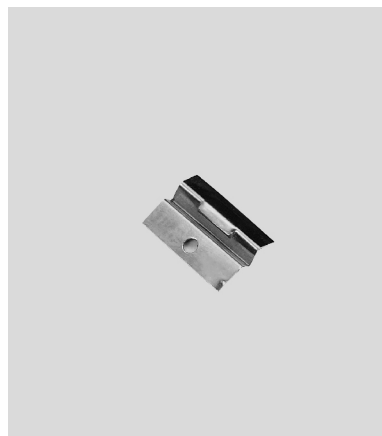
DC acciaio decapato | *black steel*

**AC 2654**

Kit fondini per profili
PR2462 - PR2474

*Fittings kit for profiles
PR2462 - PR2474*

DC acciaio decapato | *black steel*

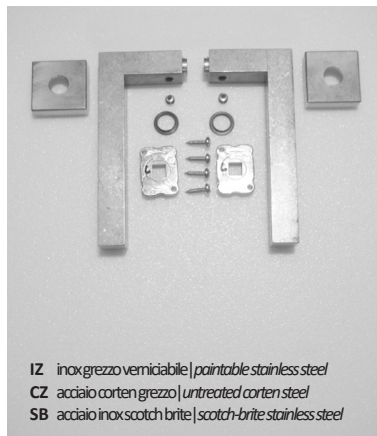
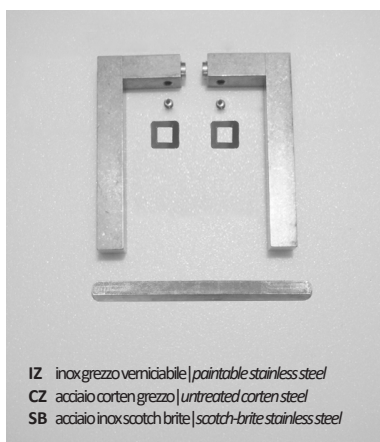
**AC 5023**

Clips per fissaggio fermavetri

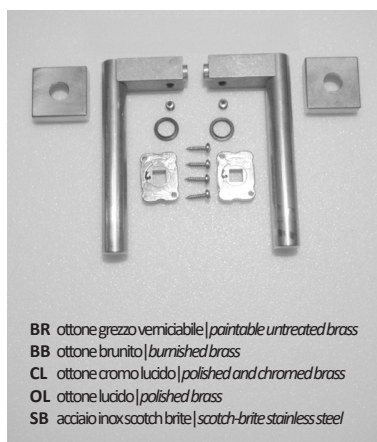
Clips for securing

**ACV 040**

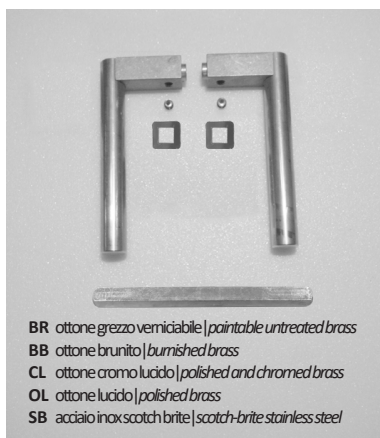
Quadro maniglia

Handle spindle bar**ACV 942**Coppia maniglie per porta
"VITRUVIO" medium
bocchetta quadrata
L | quadra | tronca*Double door handlesets
"VITRUVIO" medium
square escutcheon
L | square | cut***ACV 902**Coppia maniglie per porta
"VITRUVIO" medium
L | quadra | tronca*Double door handlesets
"VITRUVIO" medium
L | square | cut*

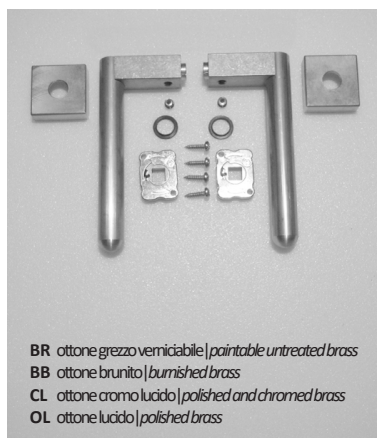
IZ inox grezzo verniciabile | paintable stainless steel
CZ acciaio corten grezzo | untreated corten steel
SB acciaio inox scotch brite | scotch-brite stainless steel

**ACV 943**Coppia maniglie per porta
"VITRUVIO" medium
bocchetta quadrata
L | tonda | tronca*Double door handlesets
"VITRUVIO" medium
square escutcheon
L | round | cut*

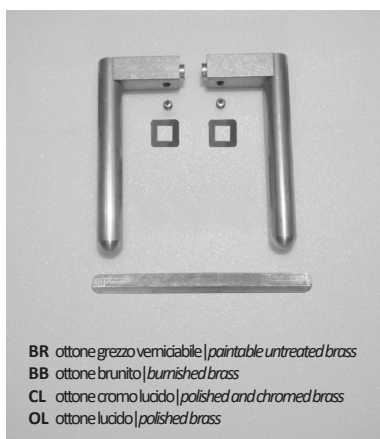
BR ottone grezzo verniciabile | paintable untreated brass
BB ottone brunito | burnished brass
CL ottone cromo lucido | polished and chromed brass
OL ottone lucido | polished brass
SB acciaio inox scotch brite | scotch-brite stainless steel

**ACV 903**Coppia maniglie per porta
"VITRUVIO" medium
L | tonda | tronca*Double door handlesets
"VITRUVIO" medium
L | round | cut*

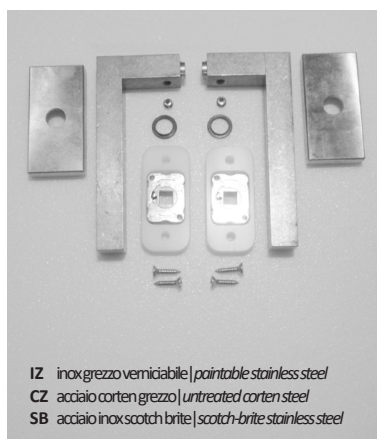
BR ottone grezzo verniciabile | paintable untreated brass
BB ottone brunito | burnished brass
CL ottone cromo lucido | polished and chromed brass
OL ottone lucido | polished brass
SB acciaio inox scotch brite | scotch-brite stainless steel

**ACV 944**Coppia maniglie per porta
"VITRUVIO" medium
bocchetta quadrata
L | tonda | sfera*Double door handlesets
"VITRUVIO" medium
square escutcheon
L | round | sphere*

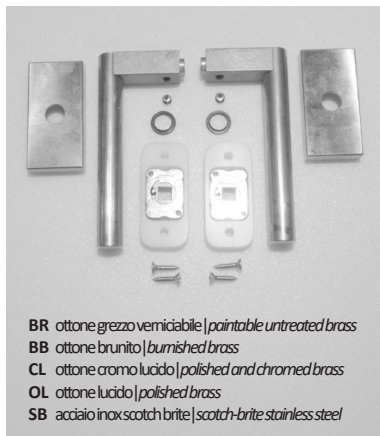
BR ottone grezzo verniciabile | paintable untreated brass
BB ottone brunito | burnished brass
CL ottone cromo lucido | polished and chromed brass
OL ottone lucido | polished brass

**ACV 904**Coppia maniglie per porta
"VITRUVIO" medium
L | tonda | sfera*Double door handlesets
"VITRUVIO" medium
L | round | sphere*

BR ottone grezzo verniciabile | paintable untreated brass
BB ottone brunito | burnished brass
CL ottone cromo lucido | polished and chromed brass
OL ottone lucido | polished brass

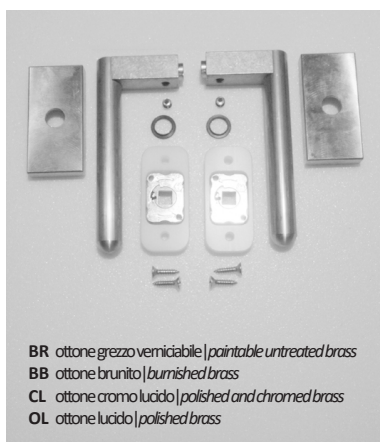
**ACV 952**Coppia maniglie per porta
"VITRUVIO" medium
bocchetta rettangolare
L | quadra | tronca*Double door handlesets
"VITRUVIO" medium
rectangular escutcheon
L | square | cut*

IZ inox grezzo verniciabile | paintable stainless steel
CZ acciaio corten grezzo | untreated corten steel
SB acciaio inox scotch brite | scotch-brite stainless steel

**ACV 953**

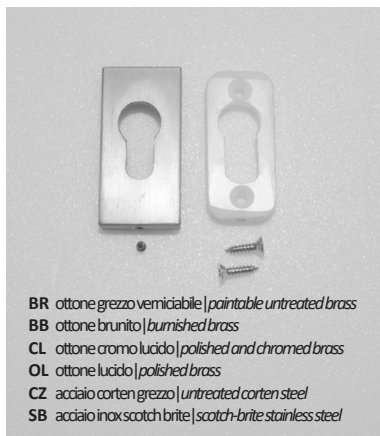
Coppia maniglie per porta
 "VITRUVIO" medium
 bocchetta rettangolare
 L | tonda | tronca

*Double door handlesets
 "VITRUVIO" medium
 rectangular escutcheon
 L | round | cut*

**ACV 954**

Coppia maniglie per porta
 "VITRUVIO" medium
 bocchetta rettangolare
 L | tonda | sfera

*Double door handlesets
 "VITRUVIO" medium
 rectangular escutcheon
 L | round | sphere*

**ACV 964**

Bocchetta copri cilindro a profilo europeo

Euro cylinder escutcheon plate

**GE 1011**

Guarnizione interna vetro
spessore 4 mm

*Internal weather strip for
glazing bead
4 mm thick*

**GU 2036**

Piattina adesiva morbida
per fondo giunto esterno vetro
12x4 mm

*Soft adhesive shim for
external window joint
12x4 mm*

**GE 2029E**

Guarnizione interna vetro
spessore 2 mm

*Internal weather strip for
glazing bead
4 mm thick*

**GU 2416**

Piattina adesiva morbida
per fondo giunto esterno vetro
10x3 mm su fermavetro PR2416

*Soft adhesive shim for
external window joint
12x4 mm on PR2416 glazing
bead*

**GE 2543TT**

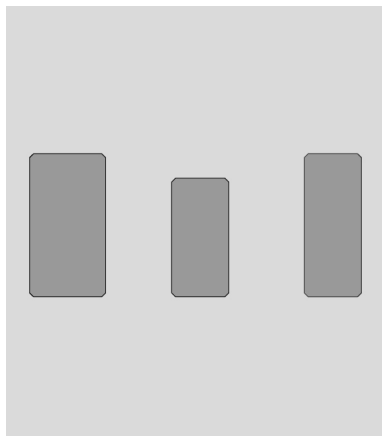
Guarnizione di battuta
interna | esterna su profili
P.2463 | P.2462

*Internal/external weather
strip with
P.2462 | P.2463
profiles*

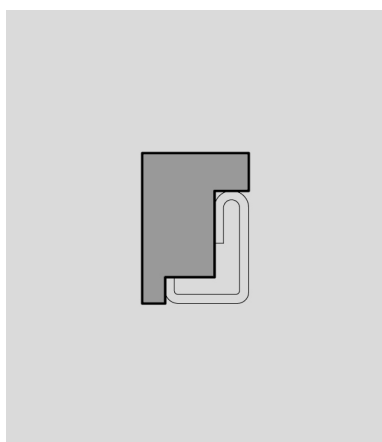
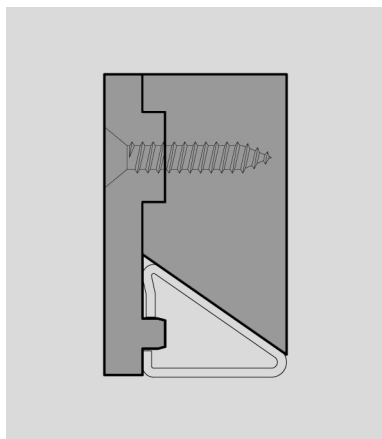
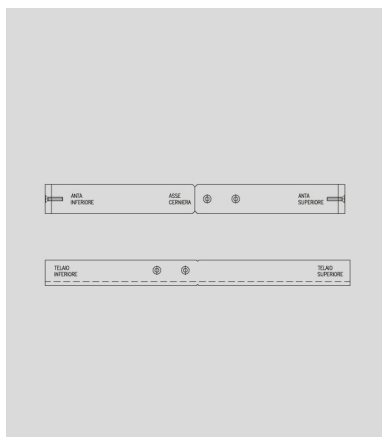
**GP 0095**

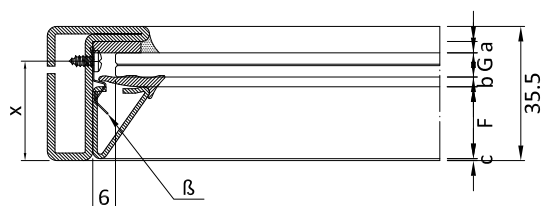
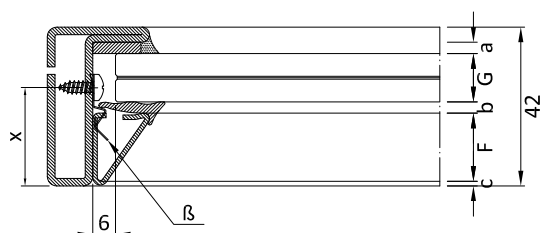
Guarnizione interna vetro
spessore 3mm

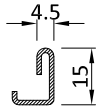
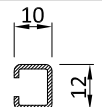
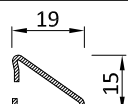
*Internal weather strip for
glazing bead
3 mm thick*

**AT 2400**

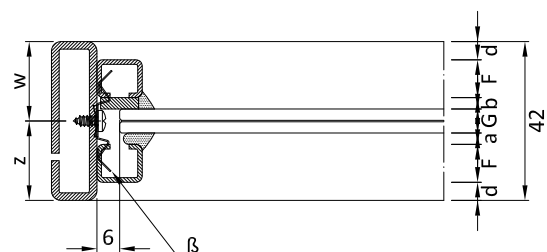
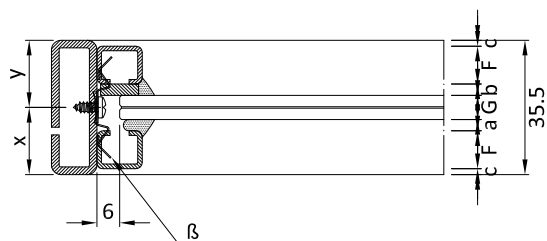
Kit ganasce di taglio

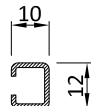
Kit of cutting jaws for profiles**AT 2415**Ganasce di taglio per
fermavetro PR2415*Kit of cutting jaws
for glazin bead PR2415***AT 2429**Ganasce di taglio per
fermavetro PR2429*Kit of cutting jaws
for glazin bead PR2429***AT 2629**Maschera per esecuzione
fori fissaggio cerniere
AC2649-AC2650*Drill jig for
AC2649-AC2650 hinges*



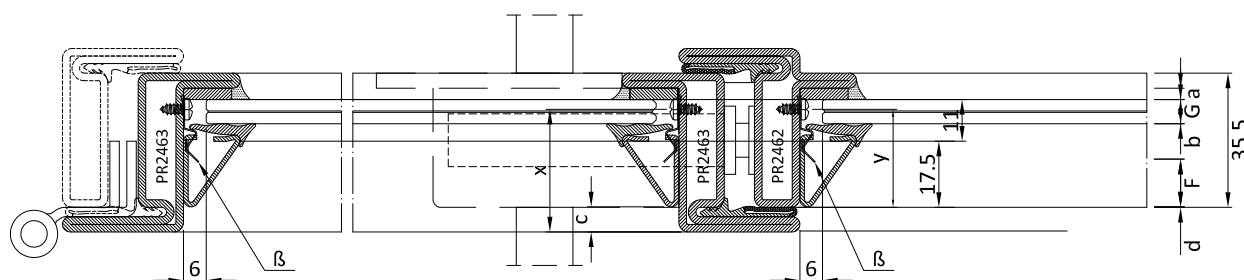
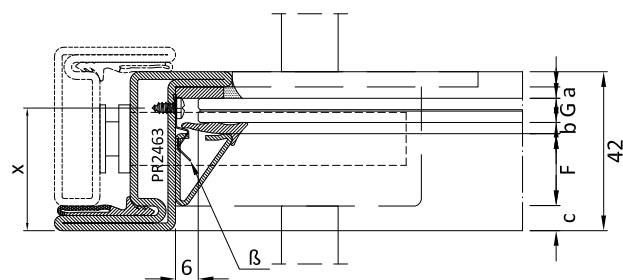
F	G		Guarnizioni - <i>gasket</i>						
fermavetro <i>glazing beads</i>	spessore vetro <i>glass thickness</i>		GU2036 3 mm  + sigillatura + <i>seal</i>	GP0095 2 / 3 mm 	asse fissaggio viti fermavetro <i>glazing beads</i> <i>securing axis</i>	rientro fermavetro <i>glazing beads</i> <i>gap</i>		clips fissaggio fermavetro <i>glazing beads</i> <i>securing clips</i>	
codice <i>Code</i>	mm		a	b	x		c		β
	Fisso 42 <i>Fix 42</i>	Fisso 35.5 <i>Fix 35.5</i>			Fisso 42 <i>Fix 42</i>	Fisso 35.5 <i>Fix 35.5</i>	Fisso 42 <i>Fix 42</i>	Fisso 35.5 <i>Fix 35.5</i>	
P.2415 	12.5 - 27.5	12.5 - 21	3	3	33 - 17.5	26.5 - 17.5	15 - 0	8.5 - 0	AC5023
P.2416 	6.5 - 22	6.5 - 15.5			32.5 - 16.5	26 - 16.5	15.5 - 0	9 - 0	AC5023
P.2429 	6.5 - 13	6.5			32.5 - 25.5	26	6.5 - 0	0	AC5023

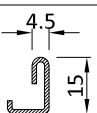
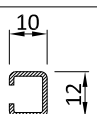
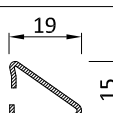
vite 3,5x9,5 mm non compresa
screw 3,5x9,5 mm not supplied



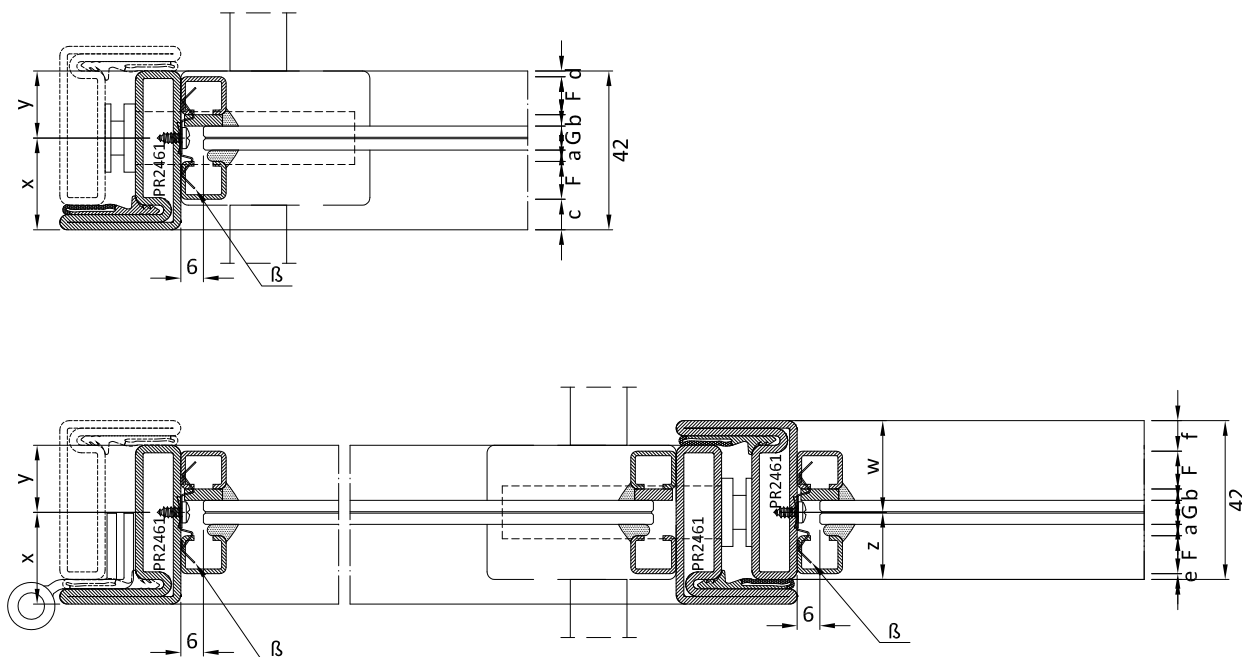
F	G		Guarnizioni - <i>gasket</i>									
fermavetro <i>glazing beads</i>	spessore vetro <i>glass thickness</i>		 sigillatura <i>seal</i>	GU2416  + sigillatura <i>+ seal</i>	asse fissaggio viti fermavetro <i>glazing beads</i> <i>securing axis</i>				rientro fermavetro <i>glazing beads</i> <i>gap</i>		clips fissaggio fermavetro <i>glazing beads</i> <i>securing clips</i>	
codice <i>Code</i>	mm		a	b	Fisso 35.5 <i>Fix 35.5</i>		Fisso 42 <i>Fix 42</i>		Fisso 35.5 <i>Fix 35.5</i>	Fisso 42 <i>Fix 42</i>	β	
	Fisso 35.5 <i>Fix 35.5</i>	Fisso 42 <i>Fix 42</i>			x	y	z	w	c	d		
P.2416 	6.5 - 9.5	6.5 - 16	3±0.5	3±0.5	17.8	17.8	21	21	1	4.5	AC5023	

vite 3,5x9,5 mm non compresa
screw 3,5x9,5 mm not supplied



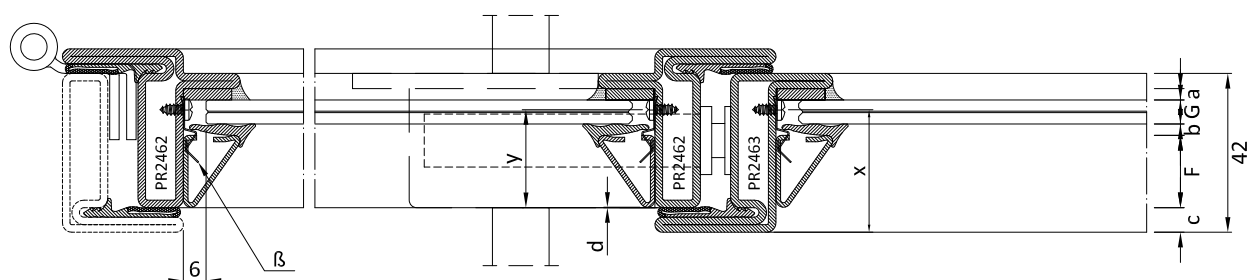
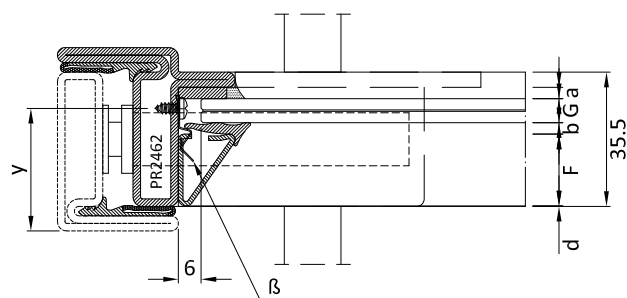
F	G	Guarnizioni - gasket						
fermavetro glazing beads	spessore vetro glass thickness	GU2036 3 mm + sigillatura + seal	GP0095 2 / 3 mm	asse fissaggio viti fermavetro glazing beads securing axis		rientro fermavetro glazing beads gap		clips fissaggio fermavetro glazing beads securing clips
codice Code	mm	a	b	x	y	c	d	β
P.2415 	12.5 - 21	3	3	24.5 - 33	26.5 - 18	15 - 6.5	8.5 - 0	AC5023
P.2416 	6.5 - 15.5			23.5 - 32.5	17 - 26	15.5 - 6.5	9 - 0	AC5023
P.2429 	6.5			32.5	26	6.5	0	AC5023

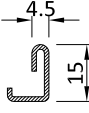
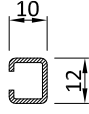
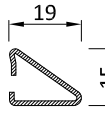
vite 3,5x9,5 mm non compresa
screw 3,5x9,5 mm not supplied



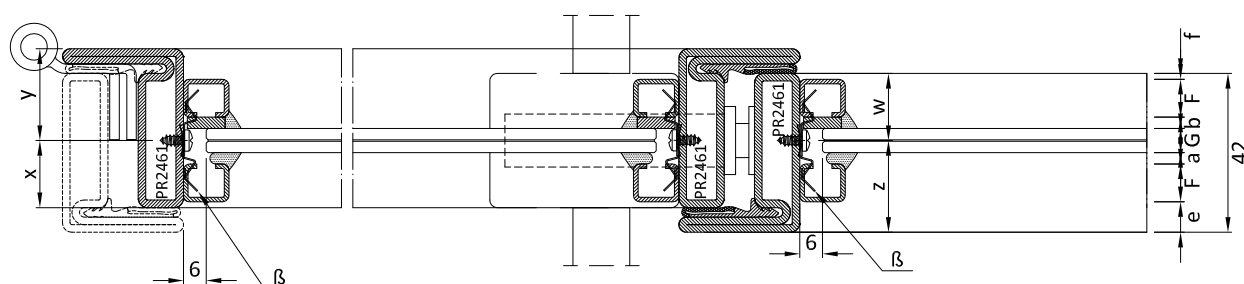
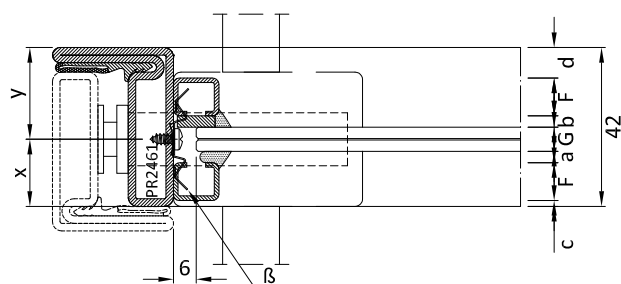
F	G		Guarnizioni - <i>gasket</i>										
fermavetro <i>glazing beads</i>	spessore vetro <i>glass thickness</i>		 3 mm sigillatura <i>seal</i>	 3 mm + sigillatura <i>+ seal</i>	asse fissaggio viti fermavetro <i>glazing beads</i> <i>securing axis</i>				rientro fermavetro <i>glazing beads</i> <i>gap</i>				clips fissaggio fermavetro <i>glazing beads</i> <i>securing clips</i>
codice <i>Code</i>	mm		a	b	1^ anta <i>1st leaf</i>		2^ anta <i>2nd leaf</i>		1^ anta <i>1st leaf</i>		2^ anta <i>2nd leaf</i>		β
	1^ anta <i>1st leaf</i>	2^ anta <i>2nd leaf</i>			x	y	z	w	c	d	e	f	
P.2416 	6.5 - 8.5	6.5 - 8.5	3±0.5	3±0.5	24.5	17.5	17.5	24.5	7.5	1	1	7.5	AC5023

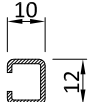
vite 3,5x9,5 mm non compresa
screw 3,5x9,5 mm not supplied



F	G	Guarnizioni - gasket						
fermavetro glazing beads	spessore vetro glass thickness	GU2036 3 mm  + sigillatura + seal	GP0095 2 / 3 mm 	asse fissaggio viti fermavetro glazing beads securing axis		rientro fermavetro glazing beads gap		clips fissaggio fermavetro glazing beads securing clips
codice Code	mm	a	b	x	y	c	d	β
P.2415 	12.5 - 21	3	3	24.5 - 33	26.5 - 18	15 - 6.5	8.5 - 0	AC5023
P.2416 	6.5 - 15.5			23.5 - 32.5	17 - 26	15.5 - 6.5	9 - 0	AC5023
P.2429 	6.5			32.5	26	6.5	0	AC5023

vite 3,5x9,5 mm non compresa
screw 3,5x9,5 mm not supplied

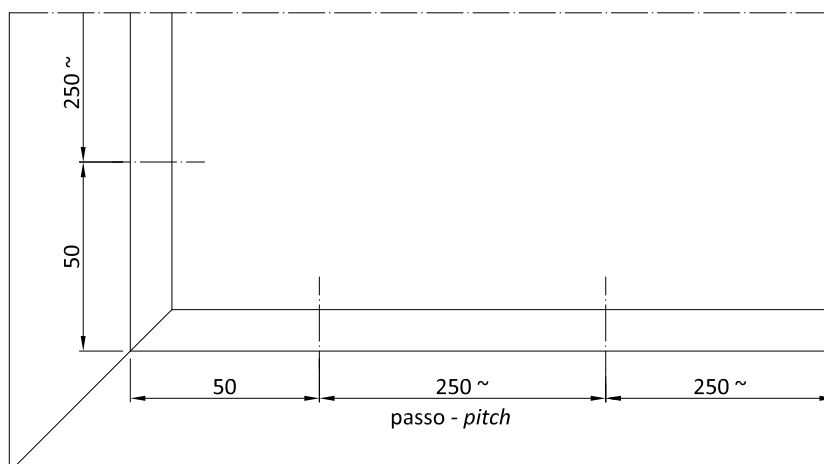


F	G		Guarnizioni - <i>gasket</i>										
fermavetro <i>glazing beads</i>	spessore vetro <i>glass thickness</i>		 sigillatura <i>seal</i>	GU2416  + sigillatura <i>+ seal</i>	asse fissaggio viti fermavetro <i>glazing beads</i> <i>securing axis</i>				rientro fermavetro <i>glazing beads</i> <i>gap</i>				clips fissaggio fermavetro <i>glazing beads</i> <i>securing clips</i>
codice <i>Code</i>	mm		a	b	1^ anta <i>1st leaf</i>		2^ anta <i>2nd leaf</i>		1^ anta <i>1st leaf</i>		2^ anta <i>2nd leaf</i>		β
					x	y	z	w	c	d	e	f	
P.2416 	6.5 - 8.5	6.5 - 8.5	3±0.5	3±0.5	17.5	24.5	24.5	17.5	1	7.5	7.5	1	AC5023

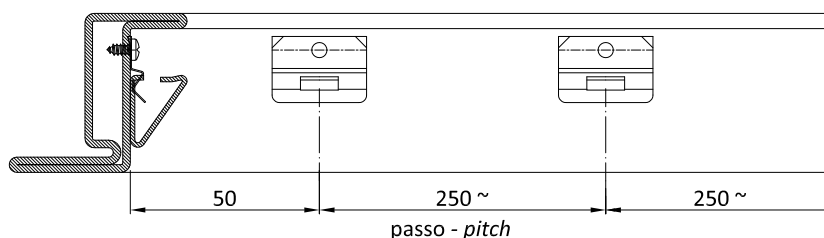
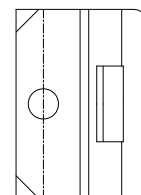
vite 3,5x9,5 mm non compresa
screw 3,5x9,5 mm not supplied

Passo clips fissaggio fermavetri
Clip pitch for glazing beads securing

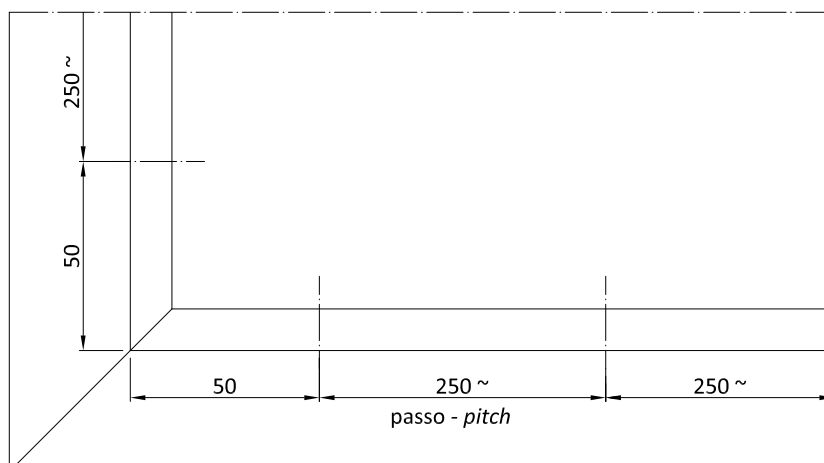
Fissaggio fermavetri P.2415 - P.2416 - P.2429: clip AC5023 con vite TC 3.5 x 9.5 (non fornite)
Glazing beads fixing P.2415 - P.2416 - P.2429: clip AC5023 with screw TC 3.5 x 9.5 (not included)



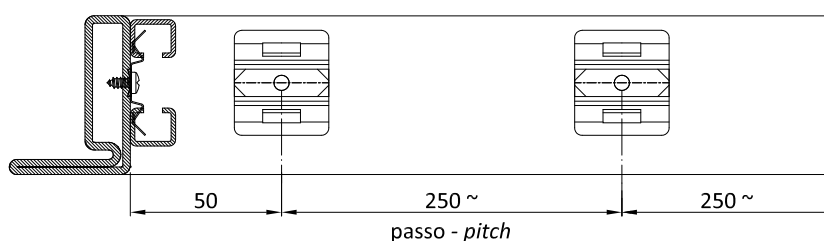
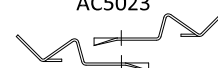
AC5023

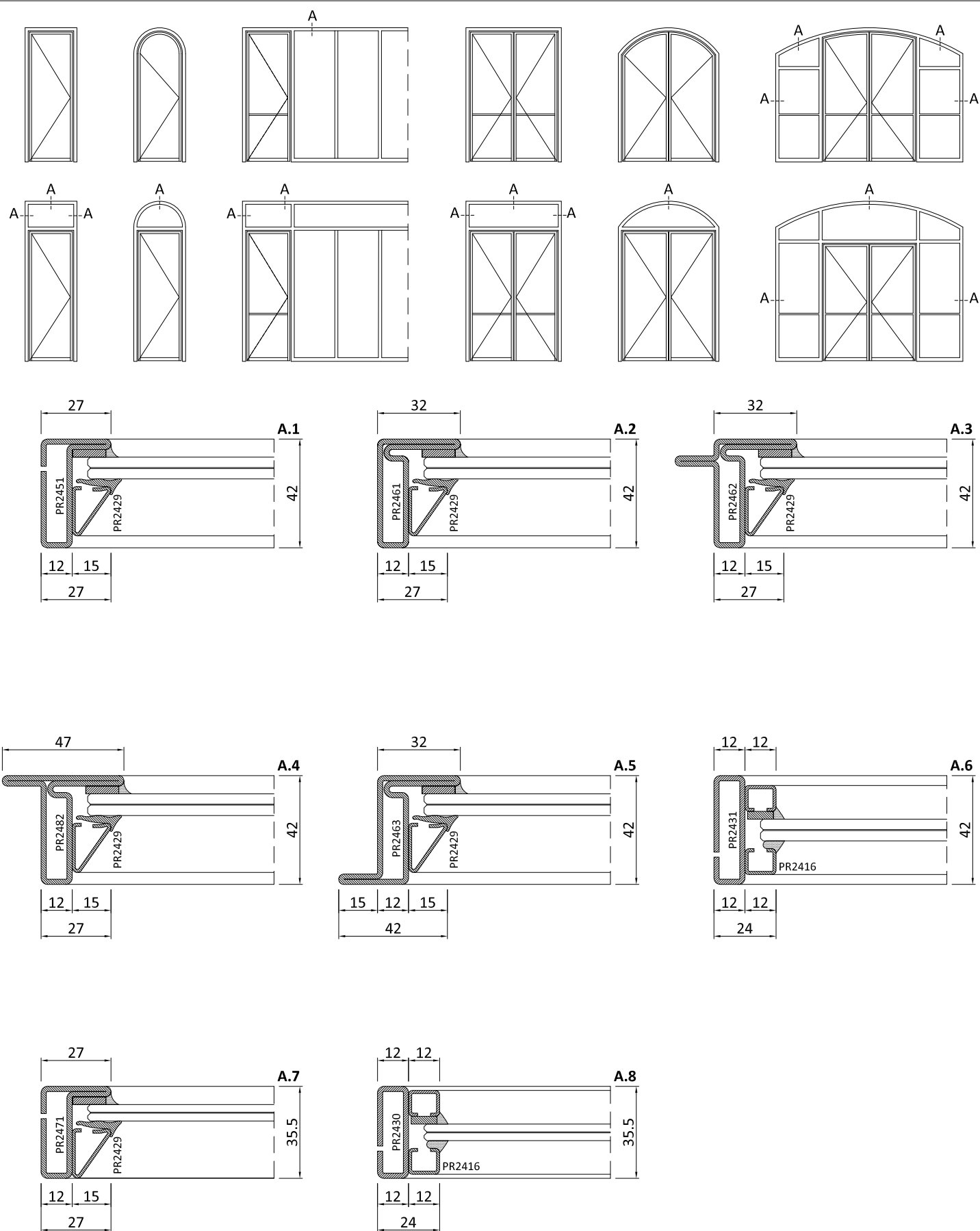


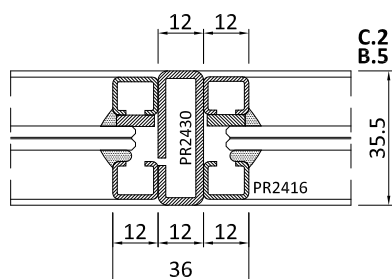
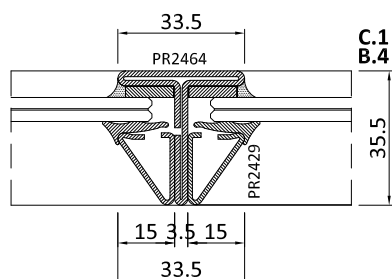
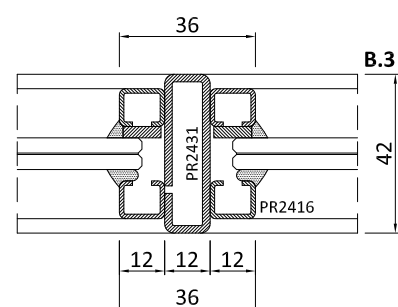
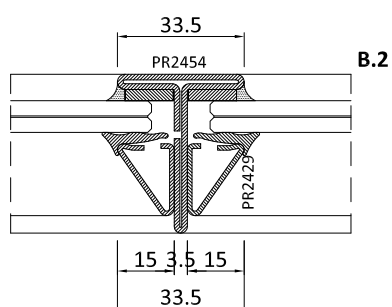
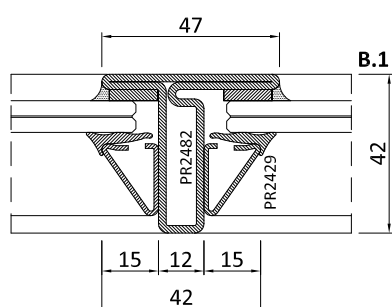
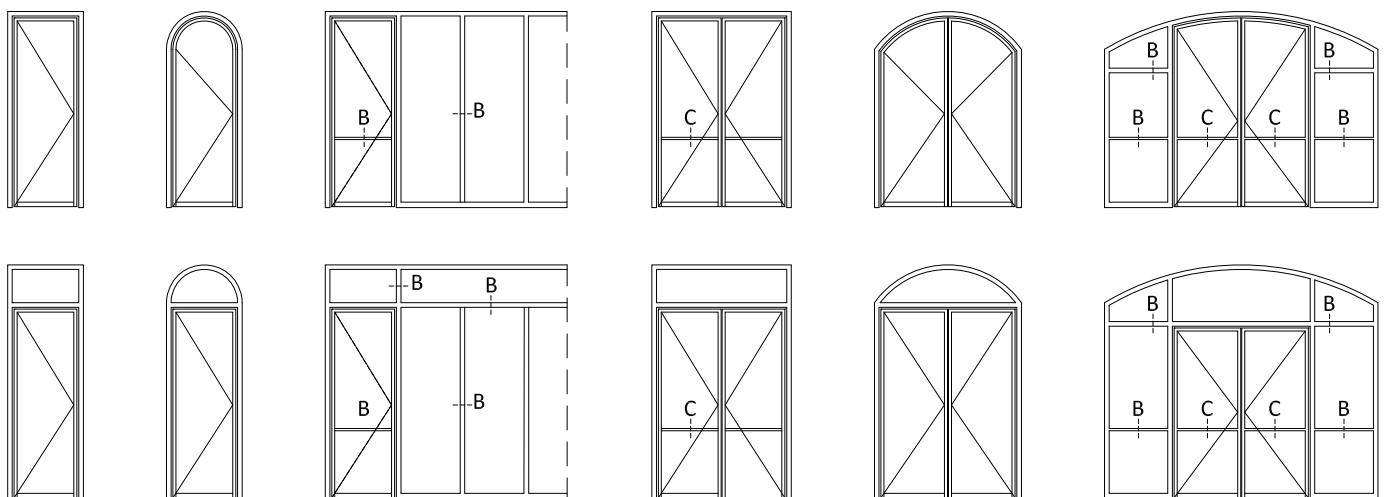
Fissaggio fermavetri P.2416: clip AC5023 con vite TC 3.5 x 9.5 (non fornite)
Glazing beads fixing P.2416: clip AC5023 with screw TC 3.5 x 9.5 (not included)

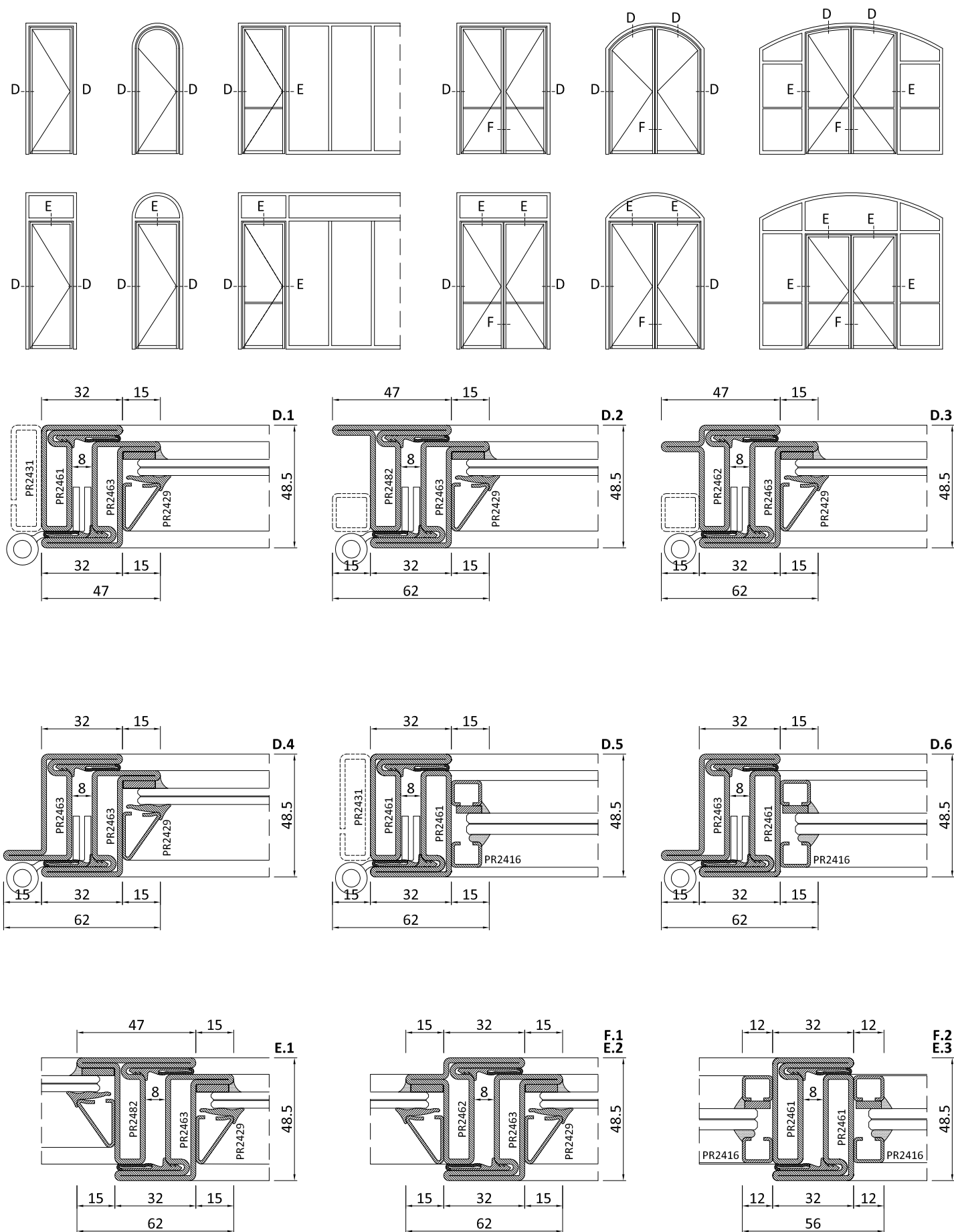


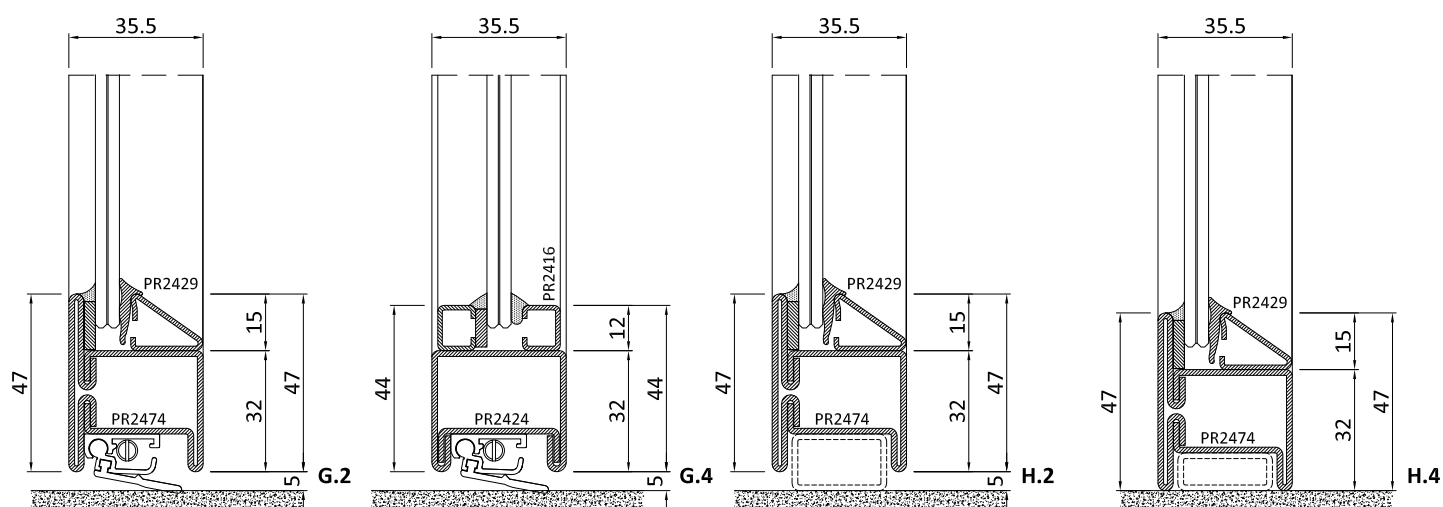
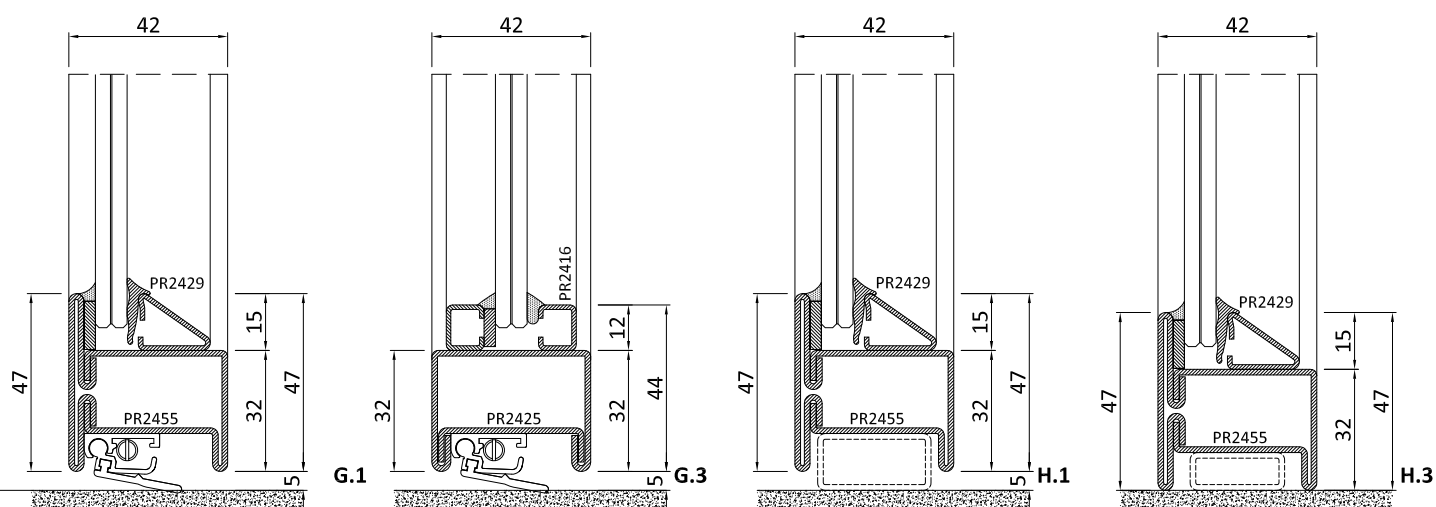
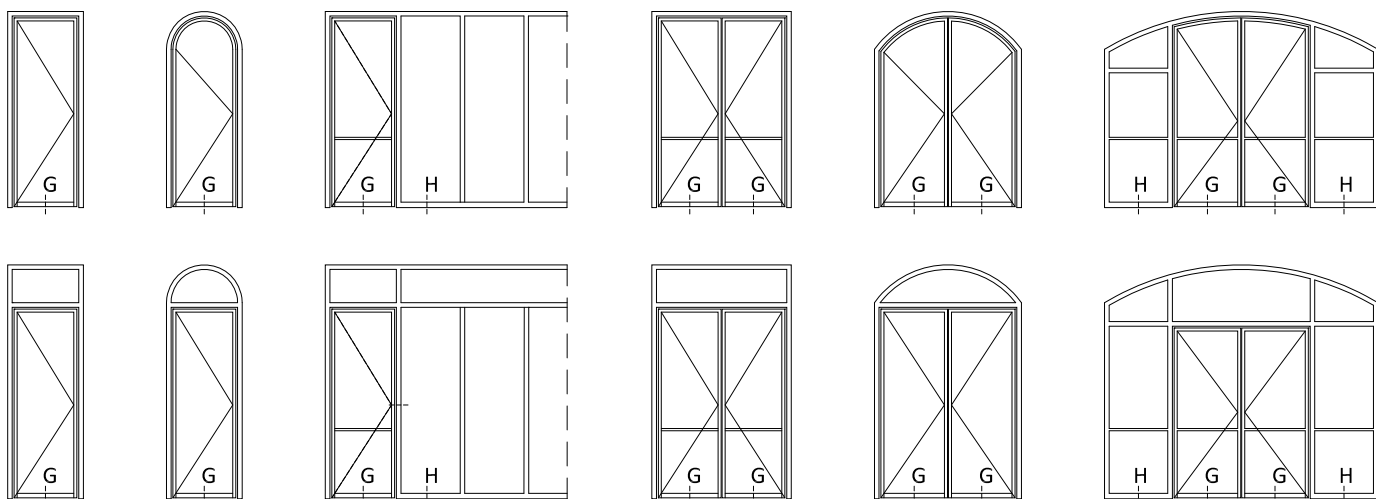
AC5023

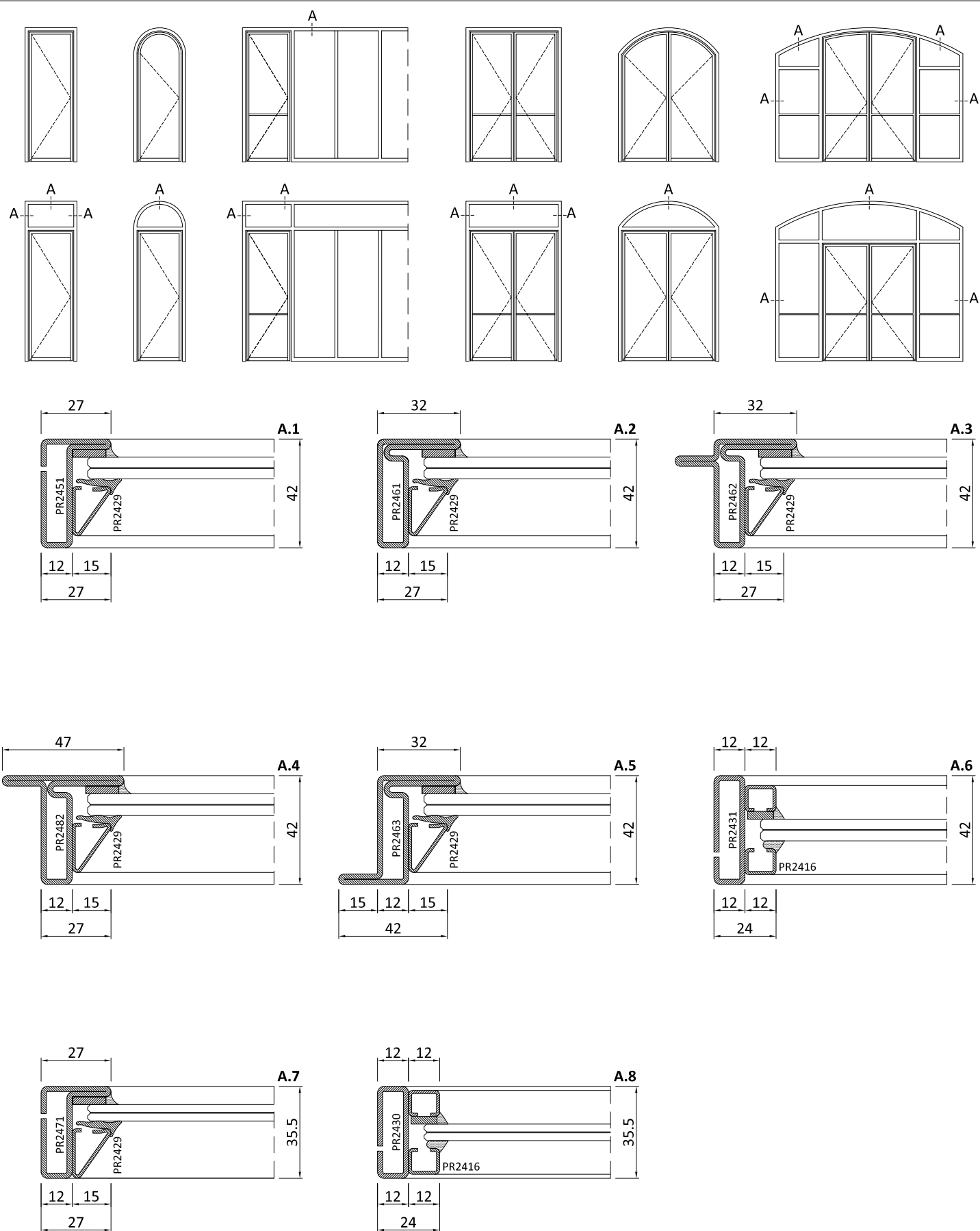


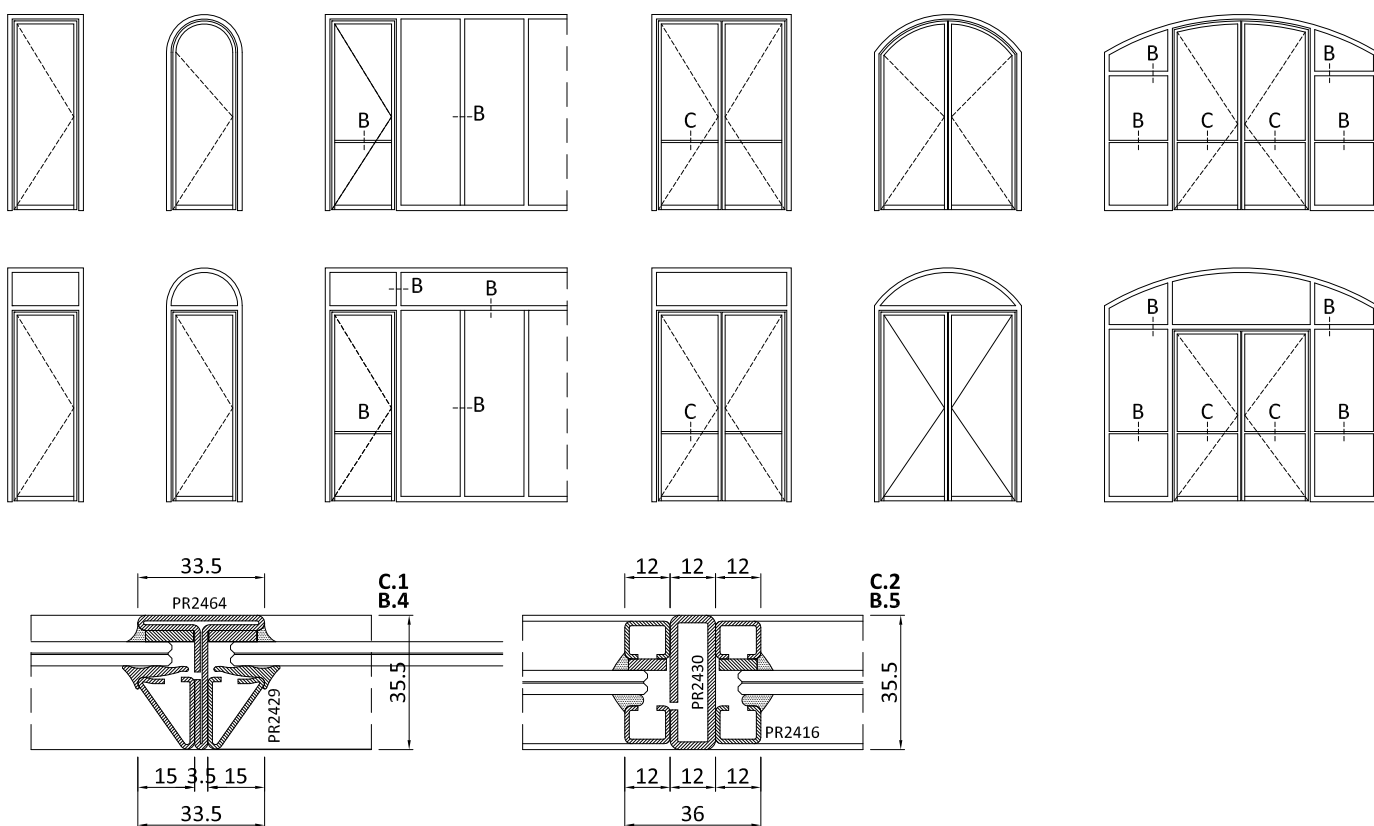


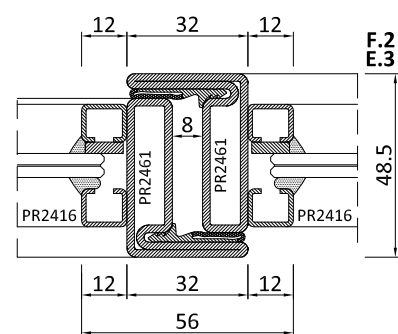
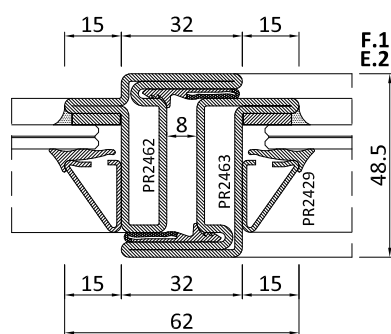
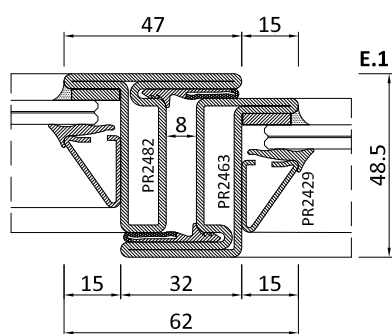
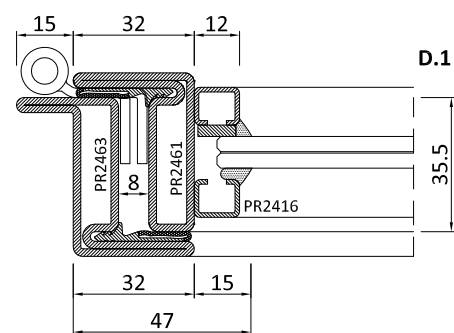
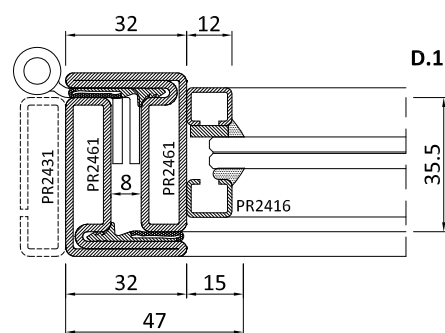
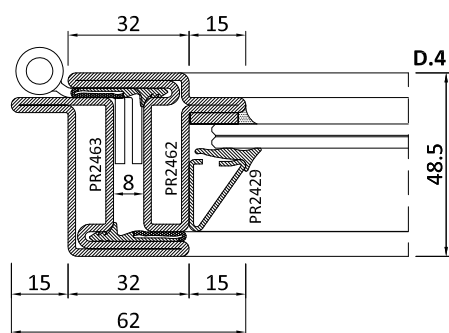
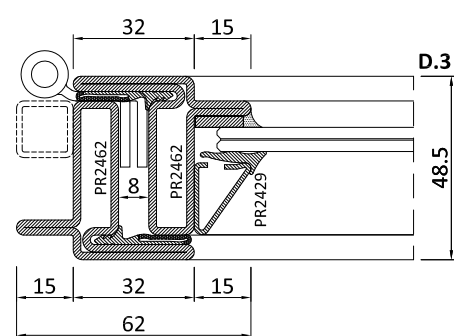
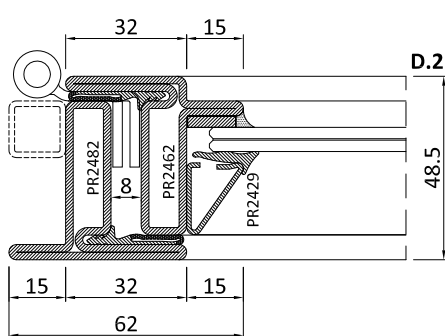
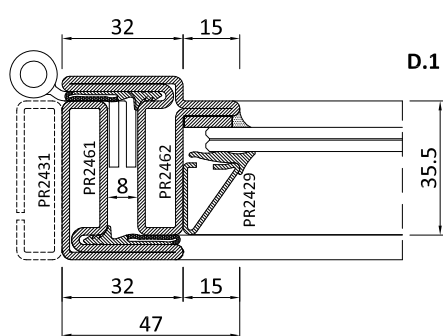
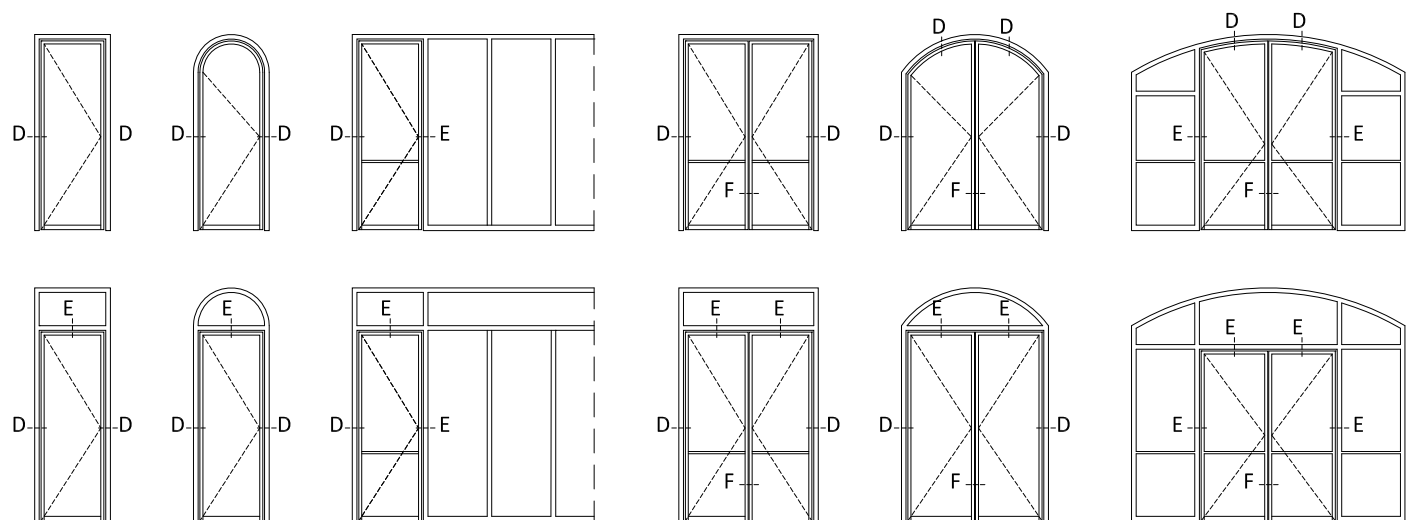


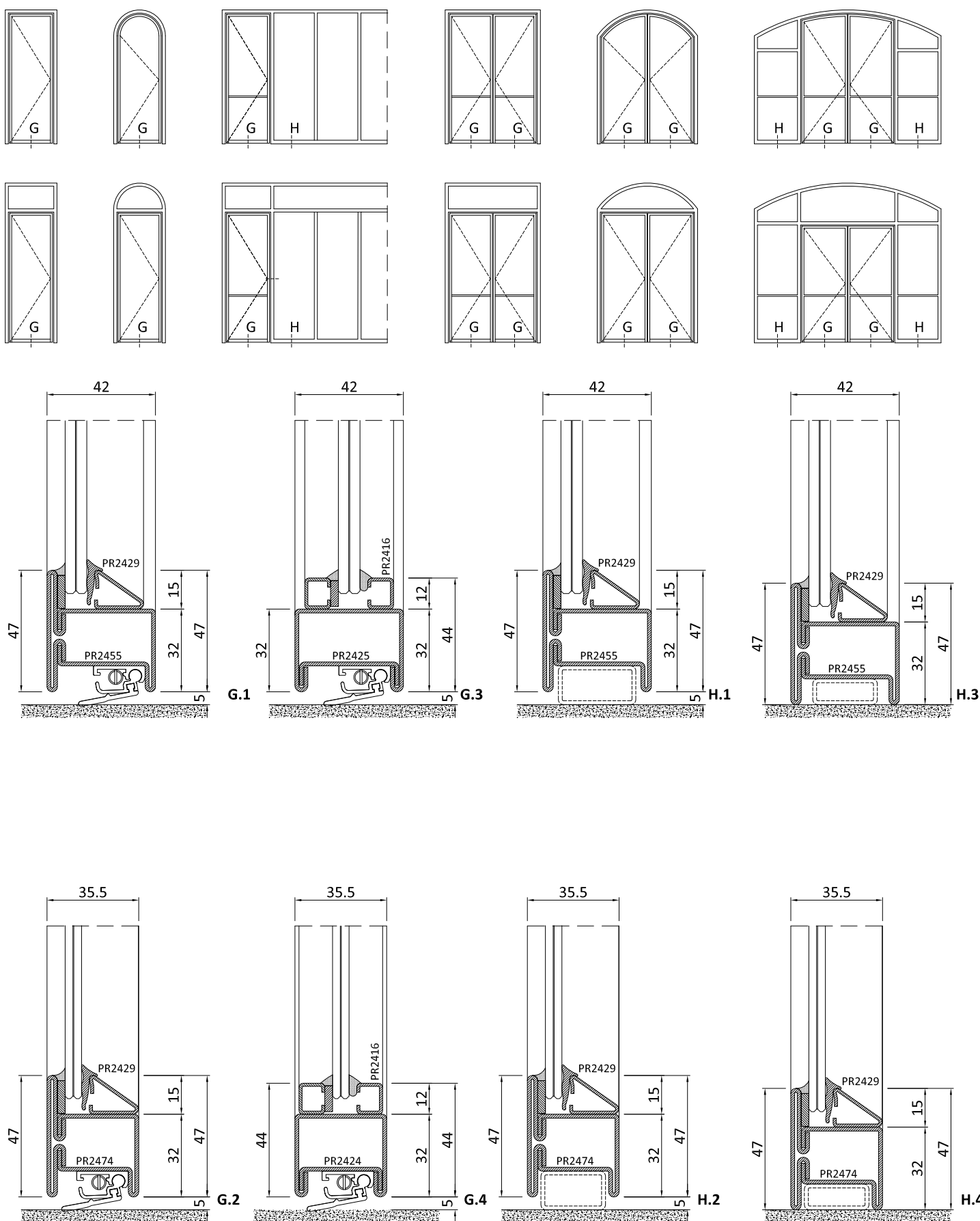


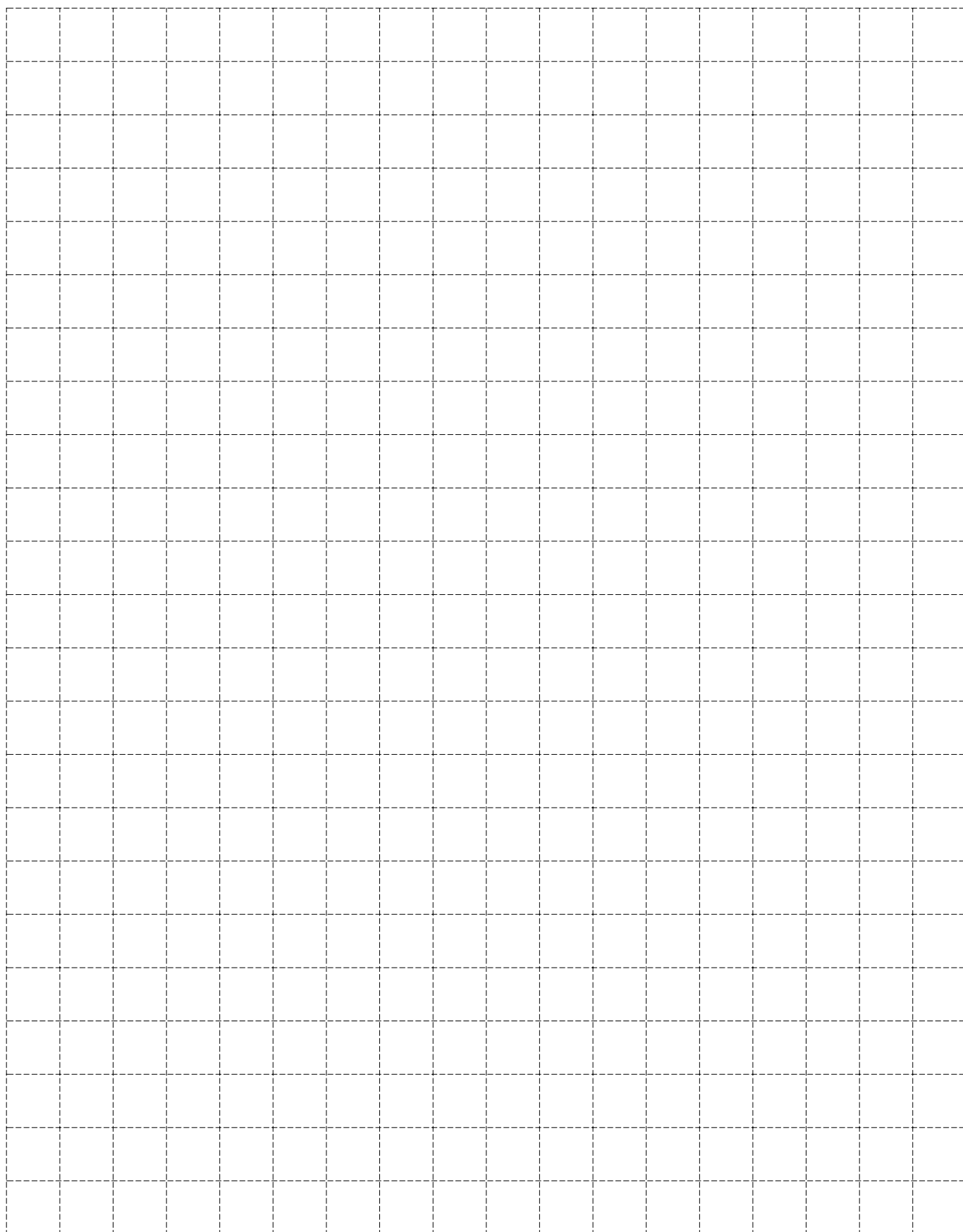


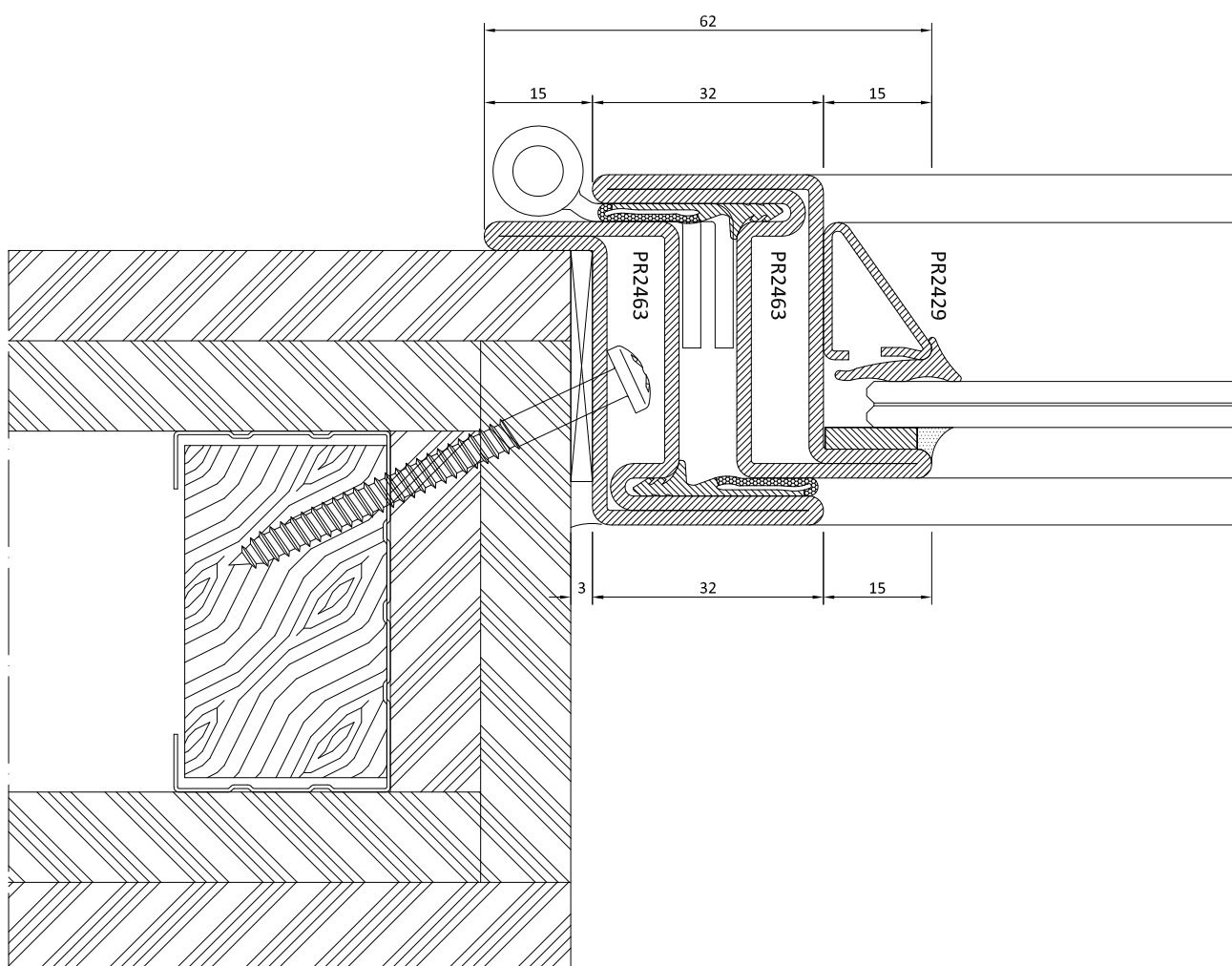
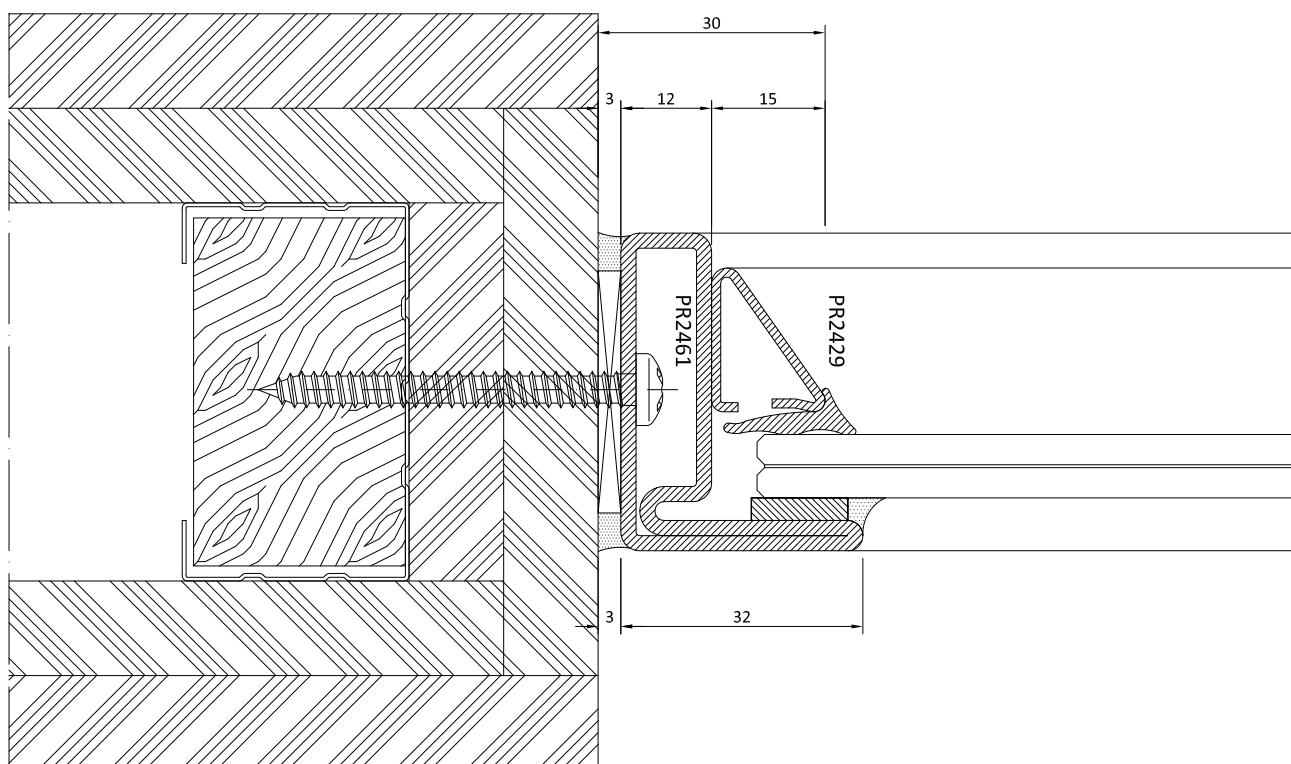


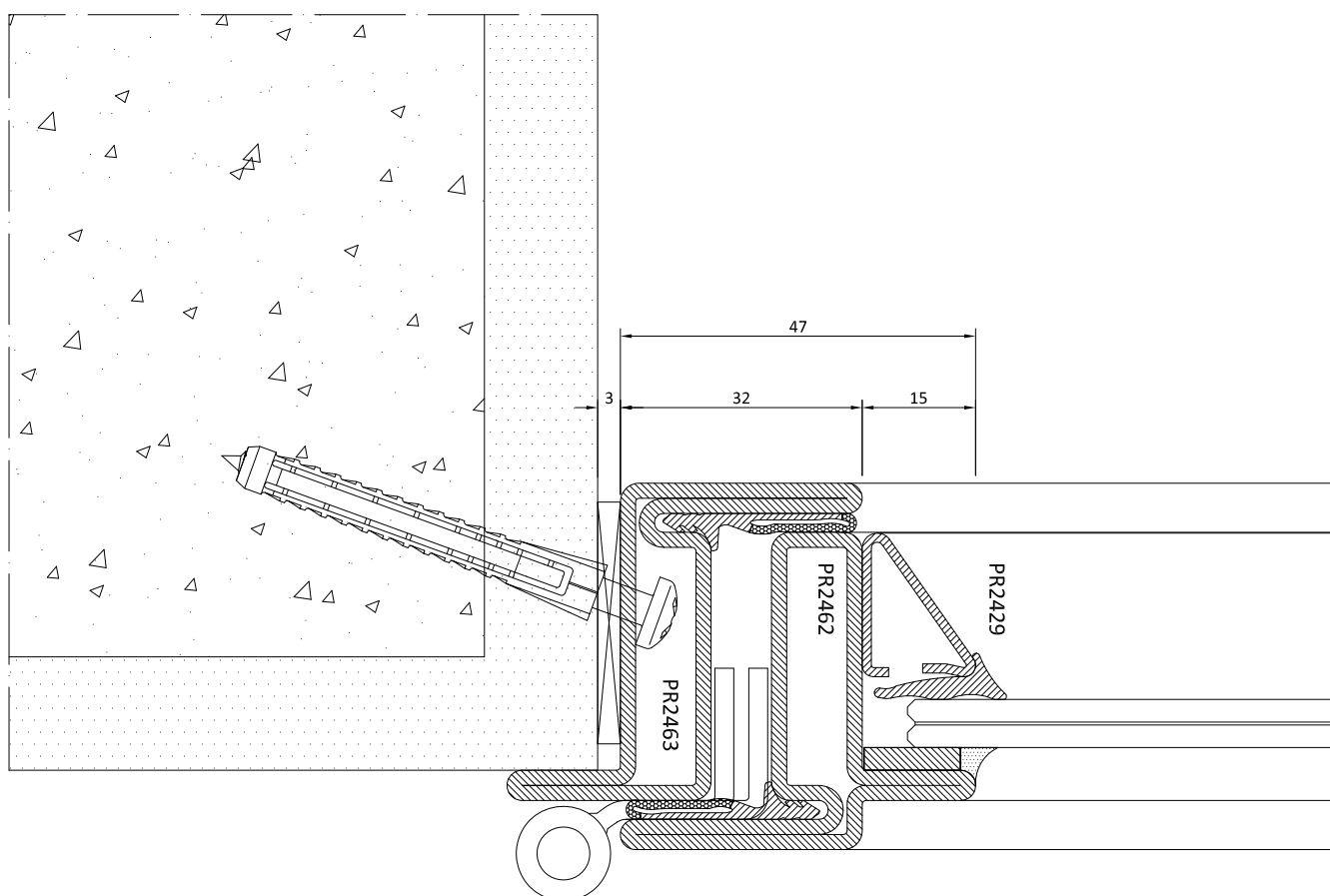
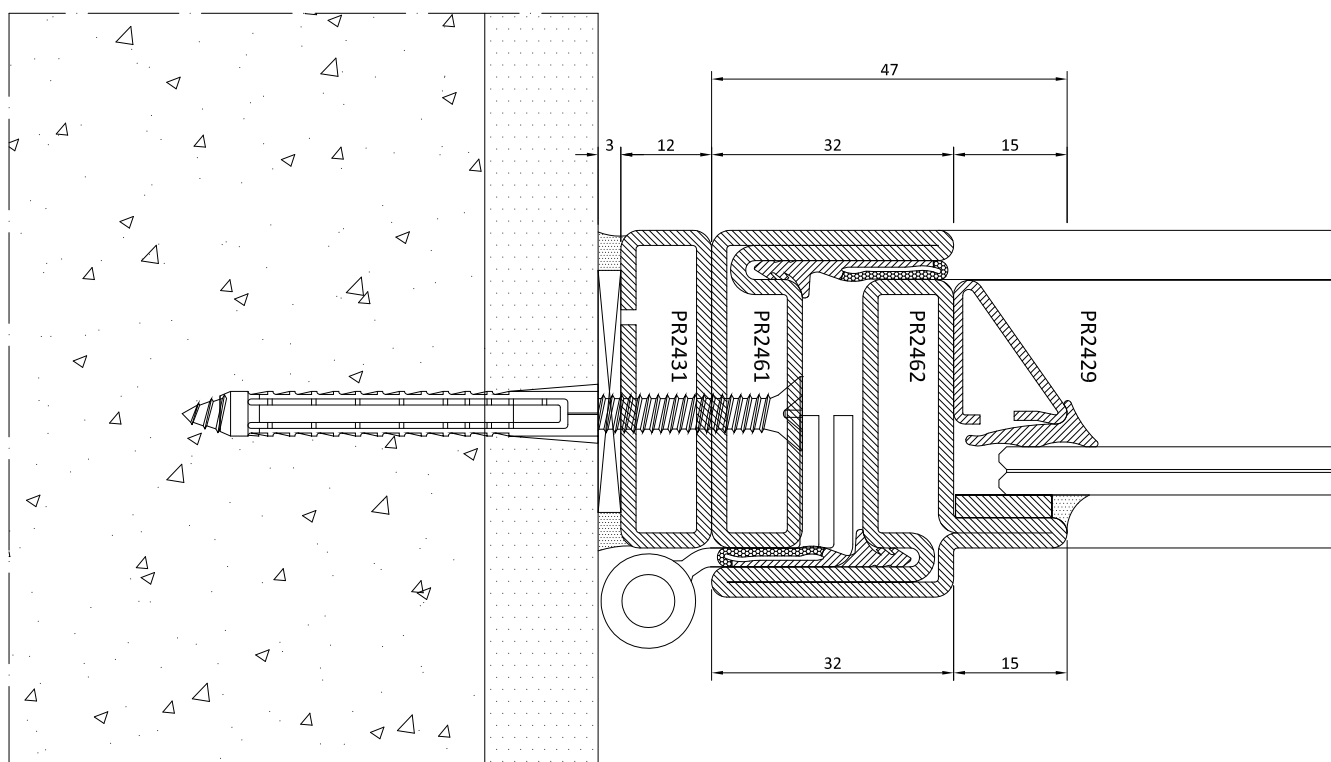


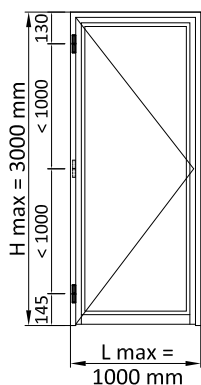








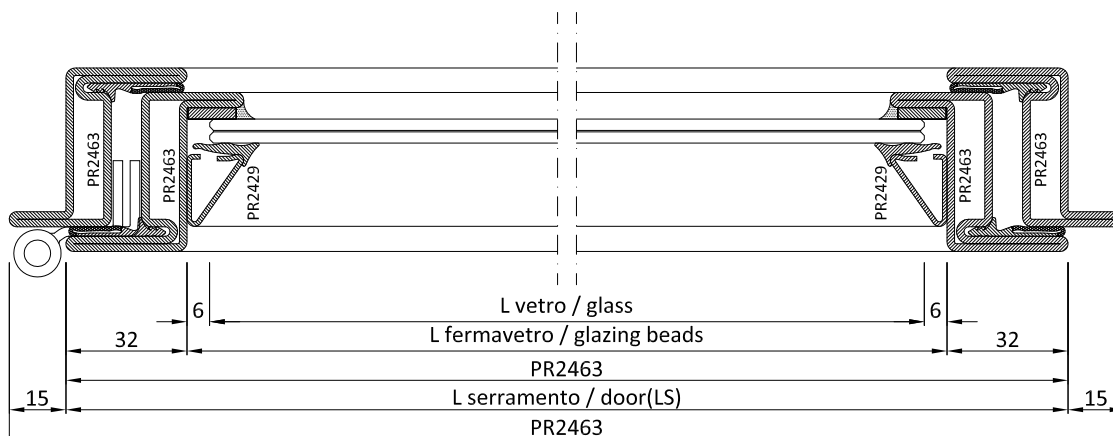
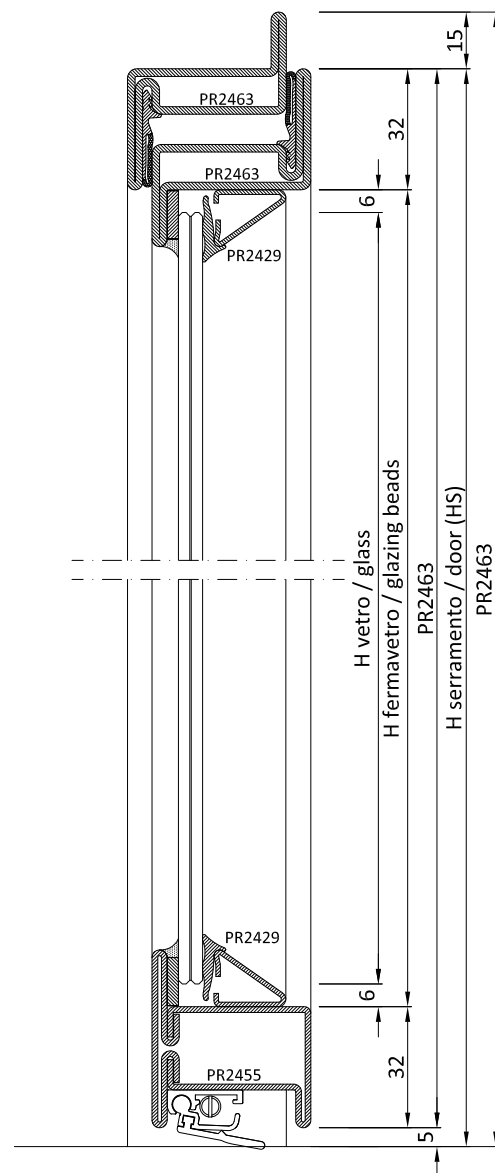


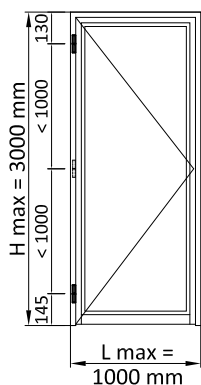


PROFILI		PROFILES				
Cod.	Descrizione	Description	n°	Dim.	Taglio	Cutting
Telaio		Frame				
PR2463	Profilo a "Z" telaio	"Z" profile frame	1	LS+30	45°	45°
PR2463	Profilo a "Z" telaio	"Z" profile frame	1	HS+15	45°	90°
PR2463	Profilo a "Z" telaio	"Z" profile frame	1	HS+15	90°	45°
Anta		Leaf				
PR2463	Profilo a "Z" anta	"Z" profile leaf	1	LS	45°	45°
PR2463	Profilo a "Z" anta	"Z" profile leaf	1	HS-5	45°	90°
PR2463	Profilo a "Z" anta	"Z" profile leaf	1	HS-5	90°	45°
PR2455	Profilo Zoccolo	Socle profile	1	LS-64	90°	90°
Fermavetri		Glazing beads				
PR2429	Profilo fermavetro	Glazing bead profile	2	LS-64	45°	45°
PR2429	Profilo fermavetro	Glazing bead profile	2	HS-69	45°	45°
Vetri		Glass unit				
-	Vetro	Insulated glass	1	LS-76 x HS-81		

ACCESSORI		HARDWARE	
Cod.	Descrizione	Description	n°
AC5023	Clips fissaggio fermavetri	Clips to secure glazing beads	Var.
AC2436/.	Guarnizione automatica	Automatic underdoor seal gasket	1
AC2494	Serratura	Lock	1
AC2496 /97	Scatola copri serratura	Lock cover box	1
AC	Cerniere	Hinges	Var.
ACV95..	Maniglia "Vitruvio"	"Vitruvio" handle	1
ACV040	Quadro Maniglia	Handle spindle bar	1
ACV964..	Bocchetta copri cilindro	Euro cylinder escutcheon plate	2

GUARNIZIONI		GASKETS	
Cod.	Descrizione	Description	n° Dim.
GE2543TT	Guarnizione esterna di battuta	Rebating gasket	1 2xLS+4xHS
GU2036	Piattina adesiva fondo giunto	Adhesive shim for joint	1 2xLS+2xHS
GP0095	Guarnizione interna vetro	Internal weather strip	1 2xLS+2xHS

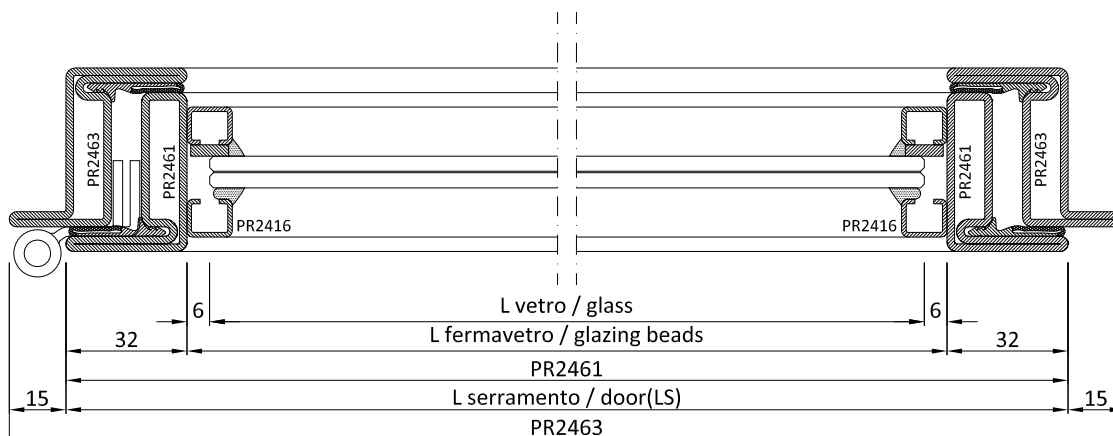
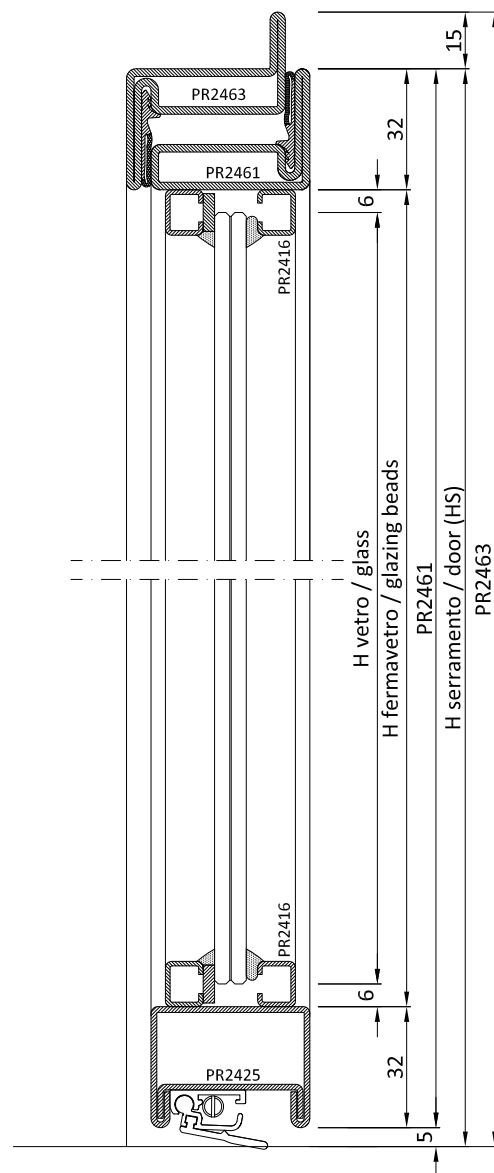


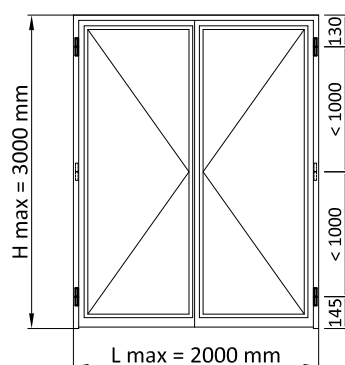


PROFILI		PROFILES				
Cod.	Descrizione	Description	n°	Dim.	Taglio	Cutting
Telaio		Frame				
PR2463	Profilo a "Z" telaio	"Z" profile frame	1	LS+30	45°	45°
PR2463	Profilo a "Z" telaio	"Z" profile frame	1	HS+15	45°	90°
PR2463	Profilo a "Z" telaio	"Z" profile frame	1	HS+15	90°	45°
Anta		Leaf				
PR2463	Profilo a "Z" anta	"Z" profile leaf	1	LS	45°	45°
PR2463	Profilo a "Z" anta	"Z" profile leaf	1	HS-5	45°	90°
PR2463	Profilo a "Z" anta	"Z" profile leaf	1	HS-5	90°	45°
PR2425	Profilo Zoccolo	Socle profile	1	LS-64	90°	90°
Fermavetri		Glazing beads				
PR2429	Profilo fermavetro	Glazing bead profile	4	LS-64	45°	45°
PR2429	Profilo fermavetro	Glazing bead profile	4	HS-69	45°	45°
Vetri		Glass unit				
-	Vetro	Insulated glass	1	LS-76 x HS-81		

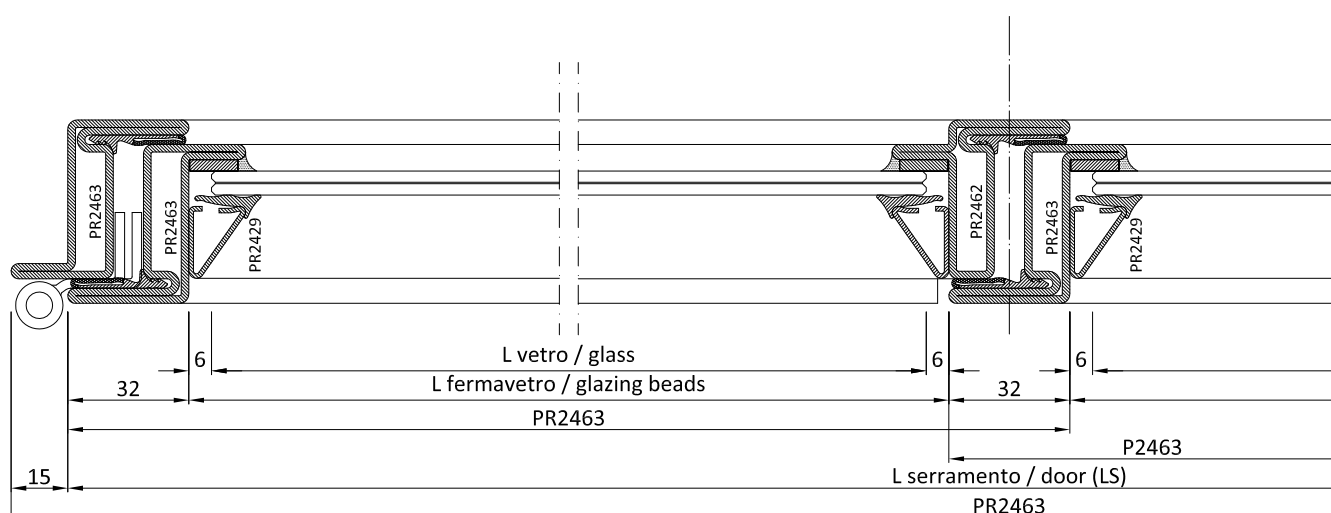
ACCESSORI		HARDWARE	
Cod.	Descrizione	Description	n°
AC5023	Clips fissaggio fermavetri	Clips to secure glazing beads	Var.
AC2436/.	Guarnizione automatica	Automatic underdoor seal gasket	1
AC2493	Serratura	Lock	1
AC2498	Scatola copri serratura	Lock cover box	1
AC	Cerniere	Hinges	Var.
ACV95..	Maniglia "Vitruvio"	"Vitruvio" handle	1
ACV040	Quadro Maniglia	Handle spindle bar	1
ACV964..	Bocchetta copri cilindro	Euro cylinder escutcheon plate	2

GUARNIZIONI		GASKETS	
Cod.	Descrizione	Description	n° Dim.
GE2543TT	Guarnizione esterna di battuta	Rebating gasket	1 2xLS+4xHS
GU2416	Piattina adesiva fondo giunto	Adhesive shim for joint	1 2xLS+2xHS
GP0095	Guarnizione interna vetro	Internal weather strip	1 2xLS+2xHS



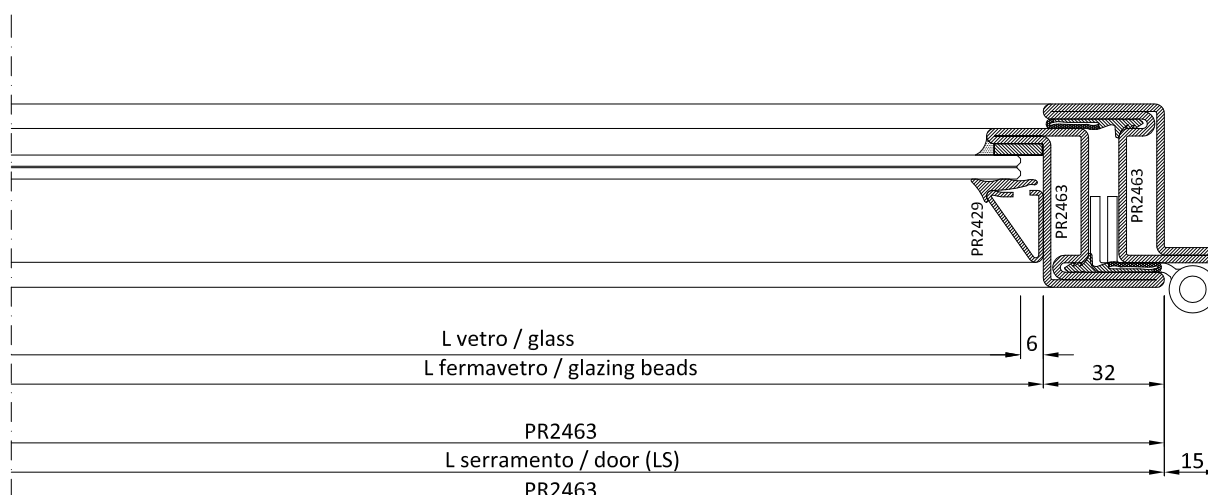
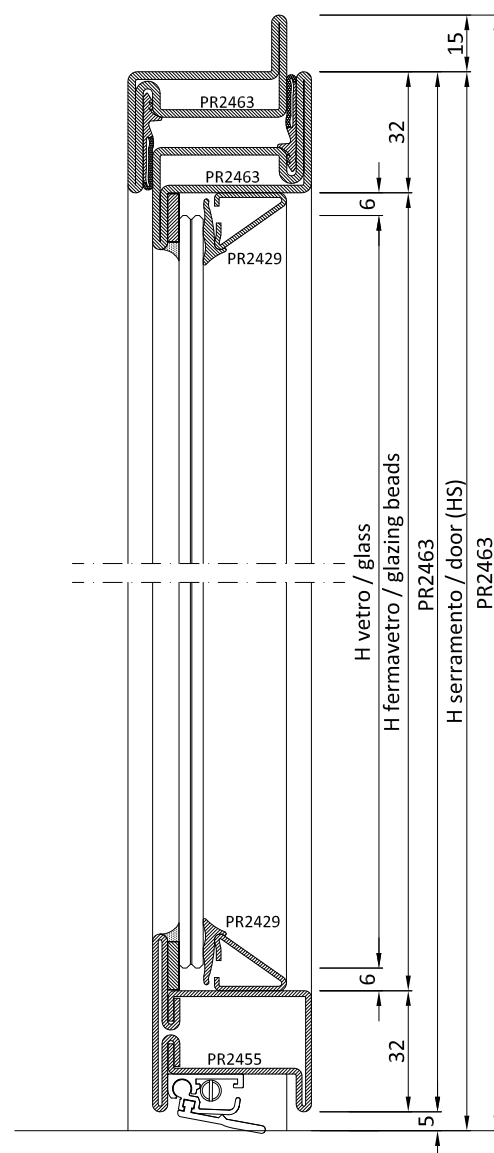


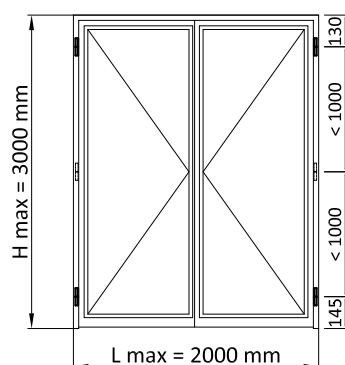
PROFILI		PROFILES			
Cod.	Descrizione	Description	n°	Dim.	Taglio Cutting
Telaio		Frame			
PR2463	Profilo a "Z" telaio	"Z" profile frame	1	LS+30	45° 45°
PR2463	Profilo a "Z" telaio	"Z" profile frame	1	HS+15	45° 90°
PR2463	Profilo a "Z" telaio	"Z" profile frame	1	HS+15	90° 45°
Anta		Leaf			
PR2463	Profilo a "Z" anta	"Z" profile leaf	2	LS/2+16	45° 45°
PR2463	Profilo a "Z" anta	"Z" profile leaf	2	HS-5	45° 90°
PR2463	Profilo a "Z" anta	"Z" profile leaf	1	HS-5	90° 45°
PR2462	Profilo a "T" anta	"T" profile leaf	1	HS-5	90° 45°
PR2455	Profilo Zoccolo	Socle profile	2	LS/2-48	90° 90°
Fermavetri		Glazing beads			
PR2429	Profilo fermavetro	Glazing bead profile	4	LS/2-48	45° 45°
PR2429	Profilo fermavetro	Glazing bead profile	4	HS-69	45° 45°
Vetri		Glass unit			
-	Vetrocamera	Insulated glass	2	LS/2-60 x HS-81	



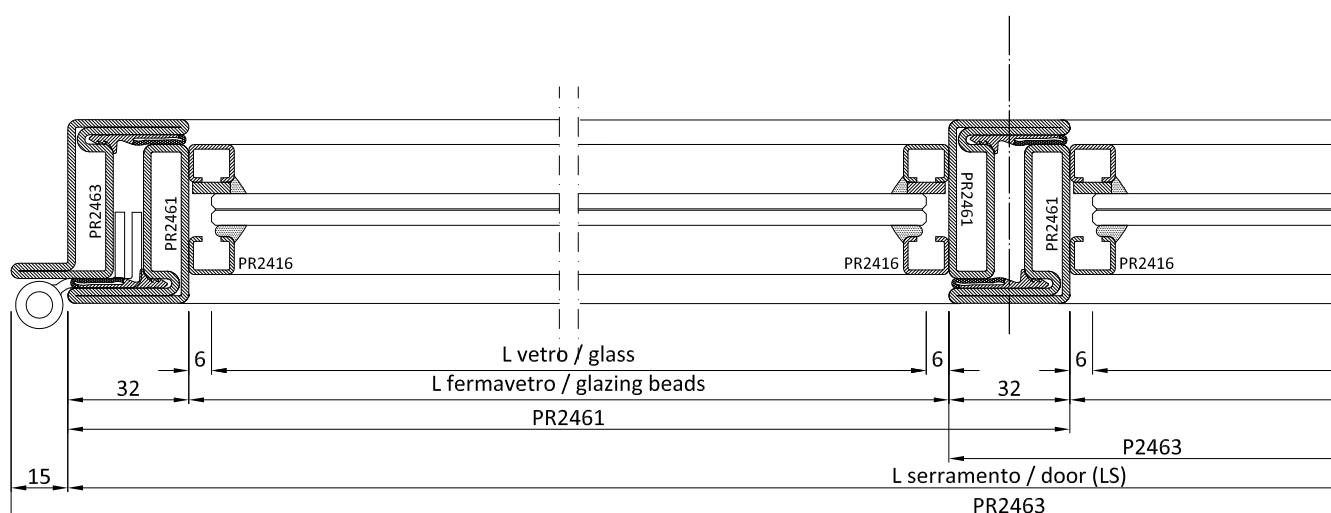
ACCESSORI		HARDWARE	
Cod.	Descrizione	Description	n°
AC5023	Clips fissaggio fermavetri	Clips to secure glazing beads	Var.
AC....	Catenaccio 2^ anta	Second leaf bolt	2
AC....	Cerniere	Hinges	Var.
AC2436..	Guarnizione automatica	Automatic bottom seal	2
AC2653	Fondino per 2^ anta	Bottom plate for second leaf	2
AC2654	Fondino per zoccolo	Bottom plate for socle	1
AC2494	Serratura	Lock	1
AC2496/ 97	Scatola copri serratura	Lock cover box	1
ACV95..	Maniglia "Vitruvio"	"Vitruvio" handle	1
ACV040	Quadro maniglia	Handle spindle bar	1
ACV964..	Bocchetta copri cilindro	Euro cylinder escutcheon plate	2

GUARNIZIONI		GASKETS		
Cod.	Descrizione	Description	n°	Dim.
GE2543TT	Guarnizione esterna di battuta	Rebating gasket	1	2xLS+6HS
GU2036	Piattina adesiva fondo giunto	Adhesive shim for joint	1	2xLS+4xHS
GP0095	Guarnizione interna vetro	Internal weather strip	1	2xLS+4xHS



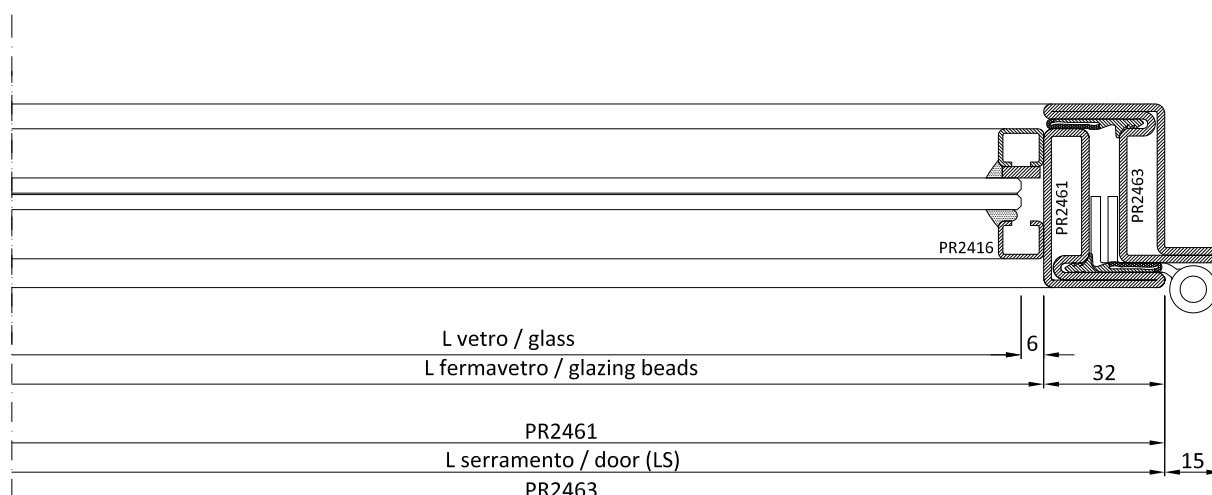
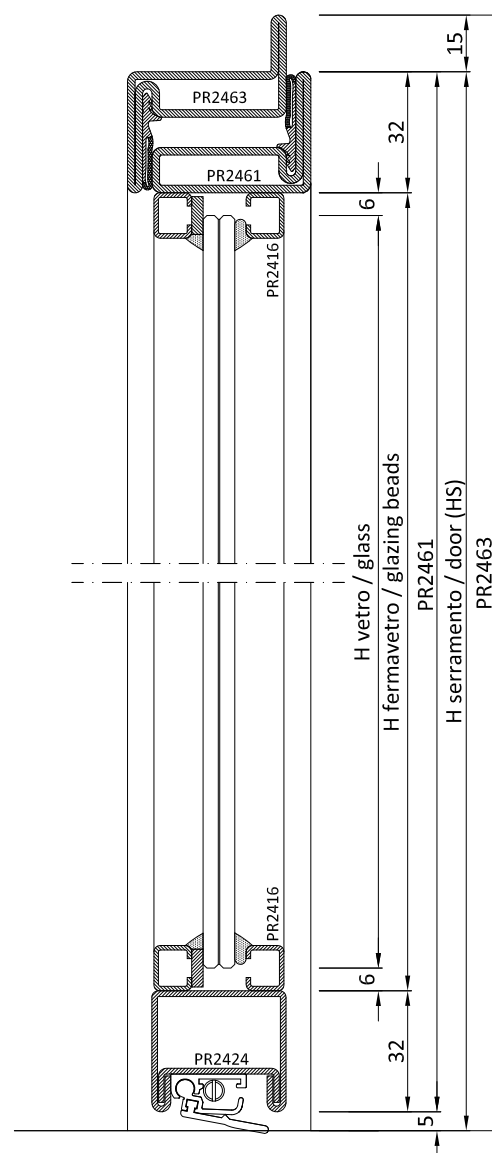


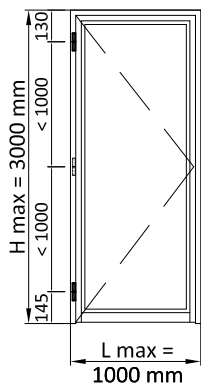
PROFILI		PROFILES			
Cod.	Descrizione	Description	n°	Dim.	Taglio Cutting
Telaio		Frame			
PR2463	Profilo a "Z" telaio	"Z" profile frame	1	LS+30	45° 45°
PR2463	Profilo a "Z" telaio	"Z" profile frame	1	HS+15	45° 90°
PR2463	Profilo a "Z" telaio	"Z" profile frame	1	HS+15	90° 45°
Anta		Leaf			
PR2461	Profilo a "Z" anta	"Z" profile leaf	2	LS/2+16	45° 45°
PR2461	Profilo a "Z" anta	"Z" profile leaf	3	HS-5	45° 90°
PR2461	Profilo a "Z" anta	"Z" profile leaf	1	HS-5	90° 45°
PR2424	Profilo Zoccolo	Socle profile	2	LS/2-48	90° 90°
Fermavetri		Glazing beads			
PR2429	Profilo fermavetro	Glazing bead profile	4	LS/2-48	45° 45°
PR2429	Profilo fermavetro	Glazing bead profile	4	HS-69	45° 45°
Vetri		Glass unit			
-	Vetrocamera	Insulated glass	2	LS/2-60 x HS-81	



ACCESSORI		HARDWARE	
Cod.	Descrizione	Description	n°
AC5023	Clips fissaggio fermavetri	Clips to secure glazing beads	Var.
AC....	Catenaccio 2^ anta	Second leaf bolt	2
AC....	Cerniere	Hinges	Var.
AC2436..	Guarnizione automatica	Automatic bottom seal	2
AC2653	Fondino per 2^ anta	Bottom plate for second leaf	2
AC2493	Serratura	Lock	1
AC2498	Scatola copri serratura	Lock cover box	1
ACV95..	Maniglia "Vitruvio"	"Vitruvio" handle	1
ACV040	Quadro maniglia	Handle spindle bar	1
ACV964..	Bocchetta copri cilindro	Euro cylinder escutcheon plate	2

GUARNIZIONI		GASKETS		
Cod.	Descrizione	Description	n°	Dim.
GE2543TT	Guarnizione esterna di battuta	Rebating gasket	1	2xLS+6HS
GU2416	Piattina adesiva fondo giunto	Adhesive shim for joint	1	2xLS+4xHS
GP0095	Guarnizione interna vetro	Internal weather strip	1	2xLS+4xHS

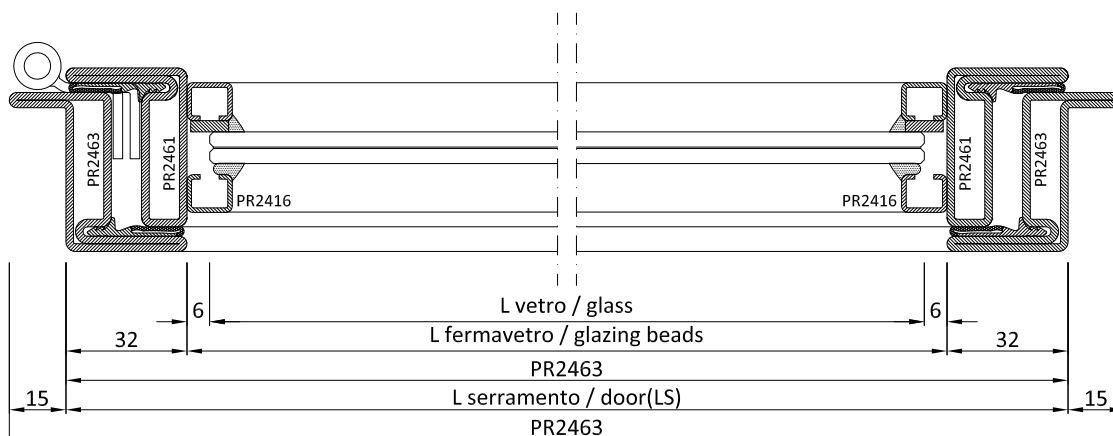
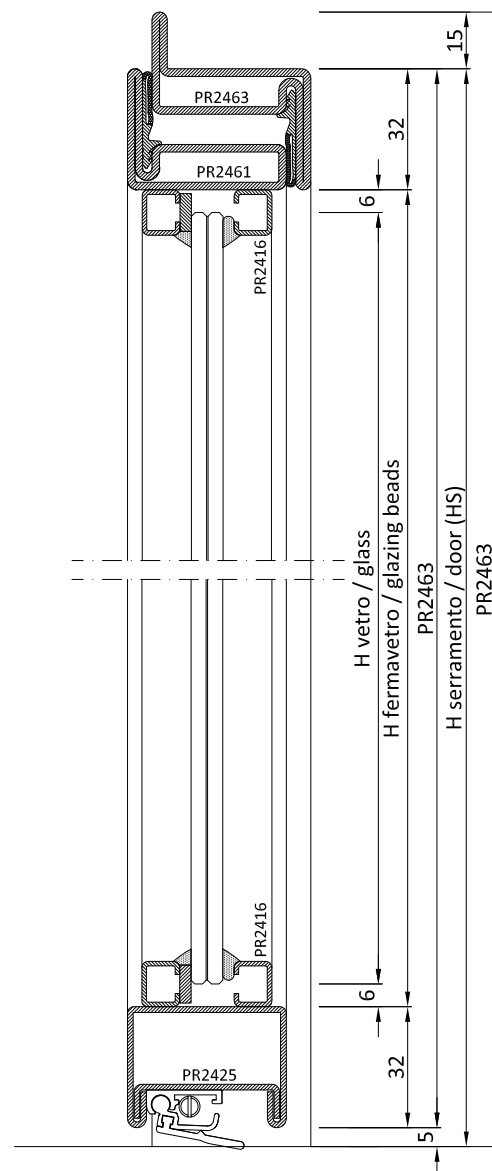


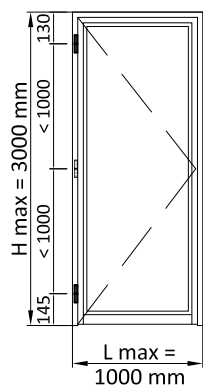


PROFILI		PROFILES				
Cod.	Descrizione	Description	n°	Dim.	Taglio	Cutting
Telaio		Frame				
PR2463	Profilo a "Z" telaio	"Z" profile frame	1	LS+30	45°	45°
PR2463	Profilo a "Z" telaio	"Z" profile frame	1	HS+15	45°	90°
PR2463	Profilo a "Z" telaio	"Z" profile frame	1	HS+15	90°	45°
Anta		Leaf				
PR2461	Profilo a "L" anta	"L" profile leaf	1	LS	45°	45°
PR2461	Profilo a "L" anta	"L" profile leaf	1	HS-5	45°	90°
PR2461	Profilo a "L" anta	"L" profile leaf	1	HS-5	90°	45°
PR2425	Profilo Zoccolo	Socle profile	1	LS-64	90°	90°
Fermavetri		Glazing beads				
PR2429	Profilo fermavetro	Glazing bead profile	4	LS-64	45°	45°
PR2429	Profilo fermavetro	Glazing bead profile	4	HS-69	45°	45°
Vetri		Glass unit				
-	Vetro	Insulated glass	1	LS-76 x HS-81		

ACCESSORI		HARDWARE			
Cod.	Descrizione	Description	n°		
AC5023	Clips fissaggio fermavetri	Clips to secure glazing beads	Var.		
AC2436/.	Guarnizione automatica	Automatic underdoor seal gasket	1		
AC2493	Serratura	Lock	1		
AC2498	Scatola copri serratura	Lock cover box	1		
AC	Cerniere	Hinges	Var.		
ACV95..	Maniglia "Vitruvio"	"Vitruvio" handle	1		
ACV040	Quadro Maniglia	Handle spindle bar	1		
ACV964..	Bocchetta copri cilindro	Euro cylinder escutcheon plate	2		

GUARNIZIONI		GASKETS			
Cod.	Descrizione	Description	n°	Dim.	
GE2543TT	Guarnizione esterna di battuta	Rebating gasket	1	2xLS+4xHS	
GU2416	Piattina adesiva fondo giunto	Adhesive shim for joint	1	2xLS+2xHS	
GP0095	Guarnizione interna vetro	Internal weather strip	1	2xLS+2xHS	

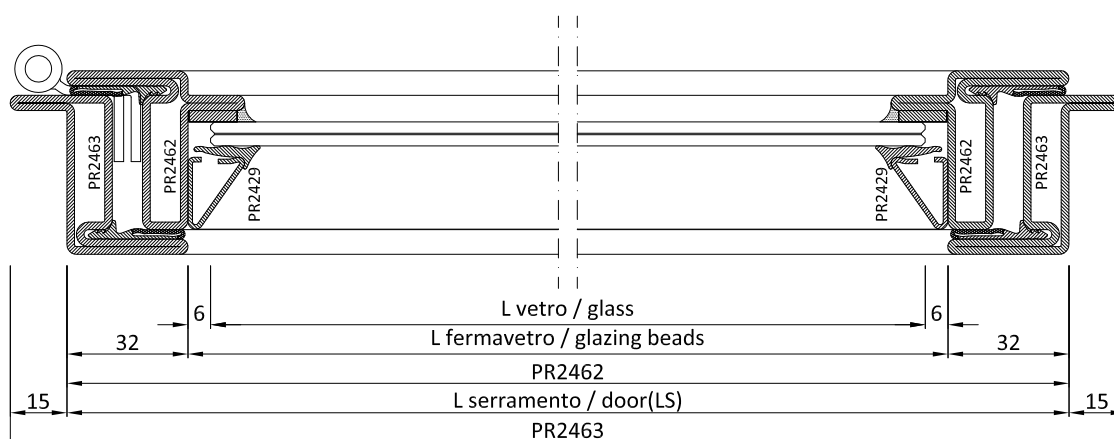
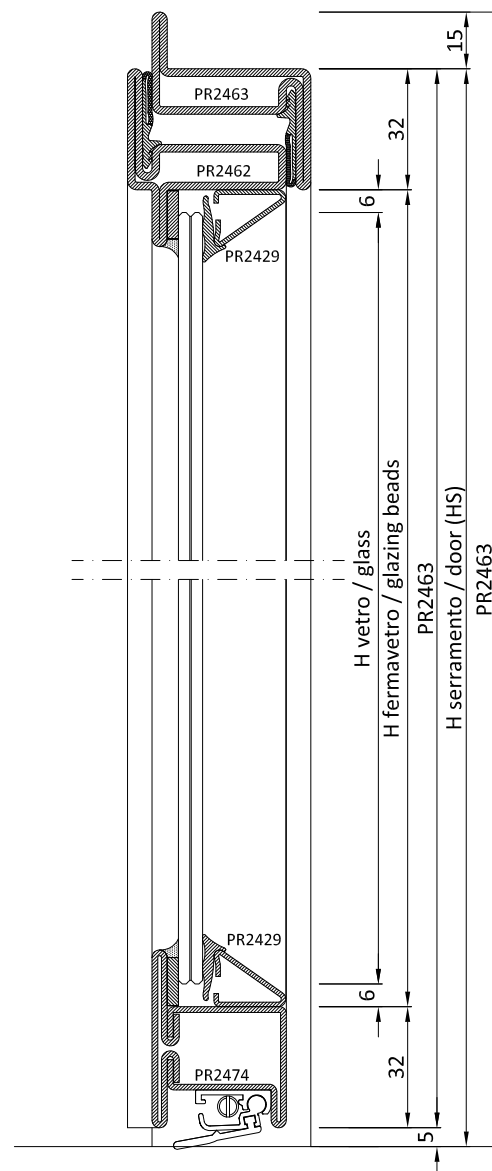


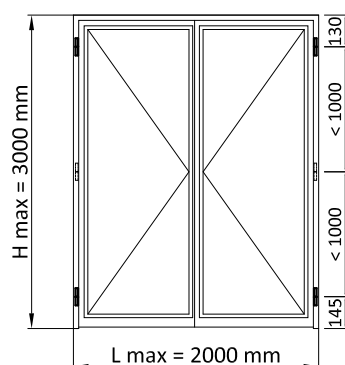


PROFILI		PROFILES				
Cod.	Descrizione	Description	n°	Dim.	Taglio	Cutting
Telaio		Frame				
PR2463	Profilo a "Z" telaio	"Z" profile frame	1	LS+30	45°	45°
PR2463	Profilo a "Z" telaio	"Z" profile frame	1	HS+15	45°	90°
PR2463	Profilo a "Z" telaio	"Z" profile frame	1	HS+15	90°	45°
Anta		Leaf				
PR2462	Profilo a "T" anta	"T" profile leaf	1	LS	45°	45°
PR2462	Profilo a "T" anta	"T" profile leaf	1	HS-5	45°	90°
PR2462	Profilo a "T" anta	"T" profile leaf	1	HS-5	90°	45°
PR2474	Profilo Zoccolo	Socle profile	1	LS-64	90°	90°
Fermavetri		Glazing beads				
PR2429	Profilo fermavetro	Glazing bead profile	2	LS-64	45°	45°
PR2429	Profilo fermavetro	Glazing bead profile	2	HS-69	45°	45°
Vetri		Glass unit				
-	Vetro	Insulated glass	1	LS-76 x HS-81		

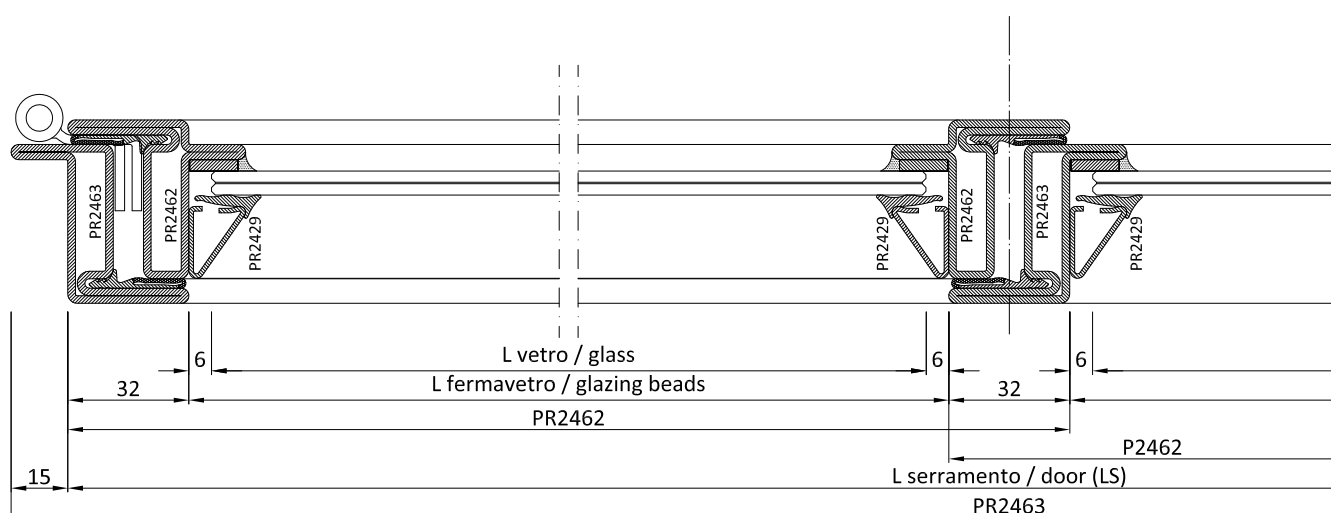
ACCESSORI		HARDWARE			
Cod.	Descrizione	Description	n°		
AC5023	Clips fissaggio fermavetri	Clips to secure glazing beads	Var.		
AC2436/.	Guarnizione automatica	Automatic underdoor seal gasket	1		
AC2494	Serratura	Lock	1		
AC2496 /97	Scatola copri serratura	Lock cover box	1		
AC	Cerniere	Hinges	Var.		
ACV95..	Maniglia "Vitruvio"	"Vitruvio" handle	1		
ACV040	Quadro Maniglia	Handle spindle bar	1		
ACV964..	Bocchetta copri cilindro	Euro cylinder escutcheon plate	2		

GUARNIZIONI		GASKETS			
Cod.	Descrizione	Description	n°	Dim.	
GE2543TT	Guarnizione esterna di battuta	Rebating gasket	1	2xLS+4xHS	
GU2036	Piattina adesiva fondo giunto	Adhesive shim for joint	1	2xLS+2xHS	
GP0095	Guarnizione interna vetro	Internal weather strip	1	2xLS+2xHS	



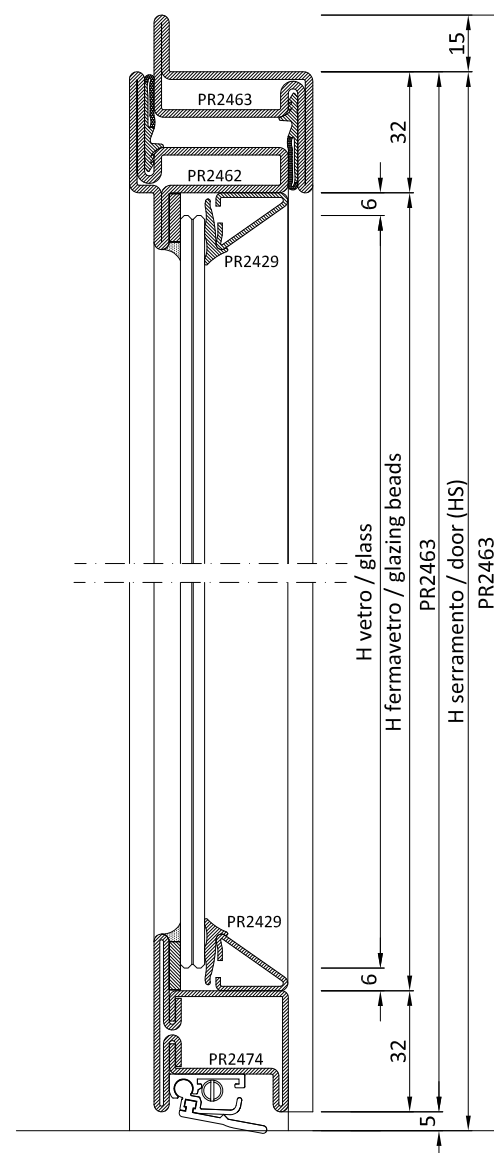


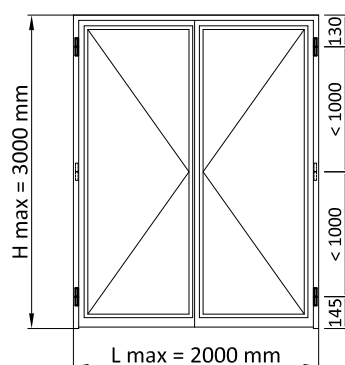
PROFILI		PROFILES			
Cod.	Descrizione	Description	n°	Dim.	Taglio Cutting
Telaio		Frame			
PR2463	Profilo a "Z" telaio	"Z" profile frame	1	LS+30	45° 45°
PR2463	Profilo a "Z" telaio	"Z" profile frame	1	HS+15	45° 90°
PR2463	Profilo a "Z" telaio	"Z" profile frame	1	HS+15	90° 45°
Anta		Leaf			
PR2462	Profilo a "T" anta	"T" profile leaf	2	LS/2+16	45° 45°
PR2462	Profilo a "T" anta	"T" profile leaf	2	HS-5	45° 90°
PR2462	Profilo a "T" anta	"T" profile leaf	1	HS-5	90° 45°
PR2463	Profilo a "Z" anta	"Z" profile leaf	1	HS-5	90° 45°
PR2474	Profilo Zoccolo	Socle profile	2	LS/2-48	90° 90°
Fermavetri		Glazing beads			
PR2429	Profilo fermavetro	Glazing bead profile	4	LS/2-48	45° 45°
PR2429	Profilo fermavetro	Glazing bead profile	4	HS-69	45° 45°
Vetri		Glass unit			
-	Vetrocamera	Insulated glass	2	LS/2-60 x HS-81	



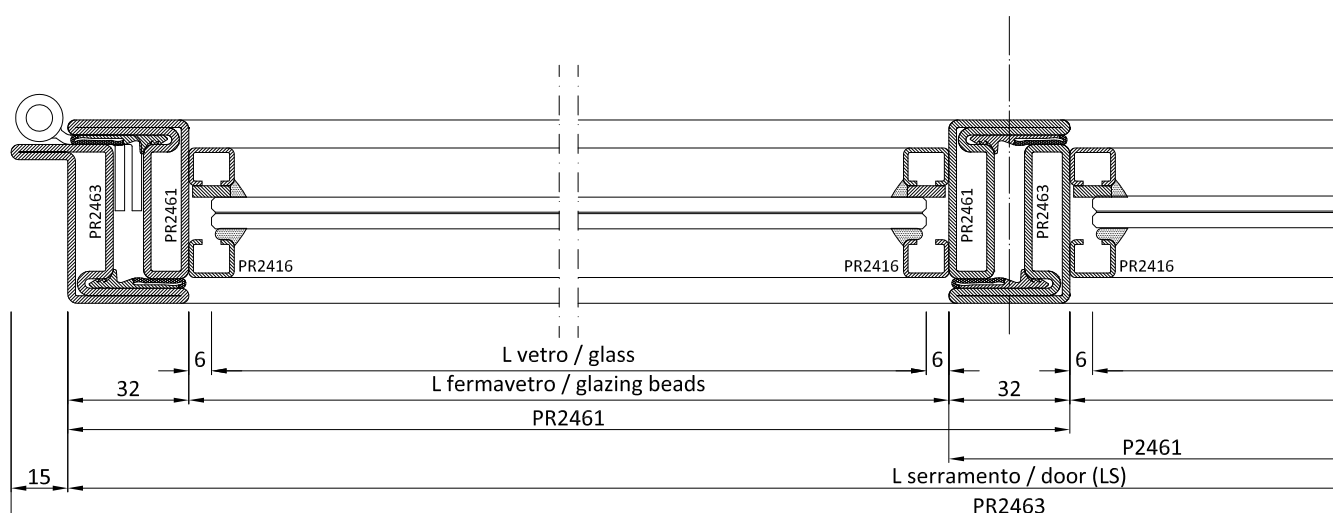
ACCESSORI		HARDWARE	
Cod.	Descrizione	Description	n°
AC5023	Clips fissaggio fermavetri	Clips to secure glazing beads	Var.
AC....	Catenaccio 2^ anta	Second leaf bolt	2
AC....	Cerniere	Hinges	Var.
AC2436..	Guarnizione automatica	Automatic bottom seal	2
AC2653	Fondino per 2^ anta	Bottom plate for second leaf	2
AC2493	Serratura	Lock	1
AC2498	Scatola copri serratura	Lock cover box	1
ACV95..	Maniglia "Vitruvio"	"Vitruvio" handle	1
ACV040	Quadro maniglia	Handle spindle bar	1
ACV964..	Bocchetta copri cilindro	Euro cylinder escutcheon plate	2

GUARNIZIONI		GASKETS		
Cod.	Descrizione	Description	n°	Dim.
GE2543TT	Guarnizione esterna di battuta	Rebating gasket	1	2xLS+6HS
GU2416	Piattina adesiva fondo giunto	Adhesive shim for joint	1	2xLS+4xHS
GP0095	Guarnizione interna vetro	Internal weather strip	1	2xLS+4xHS



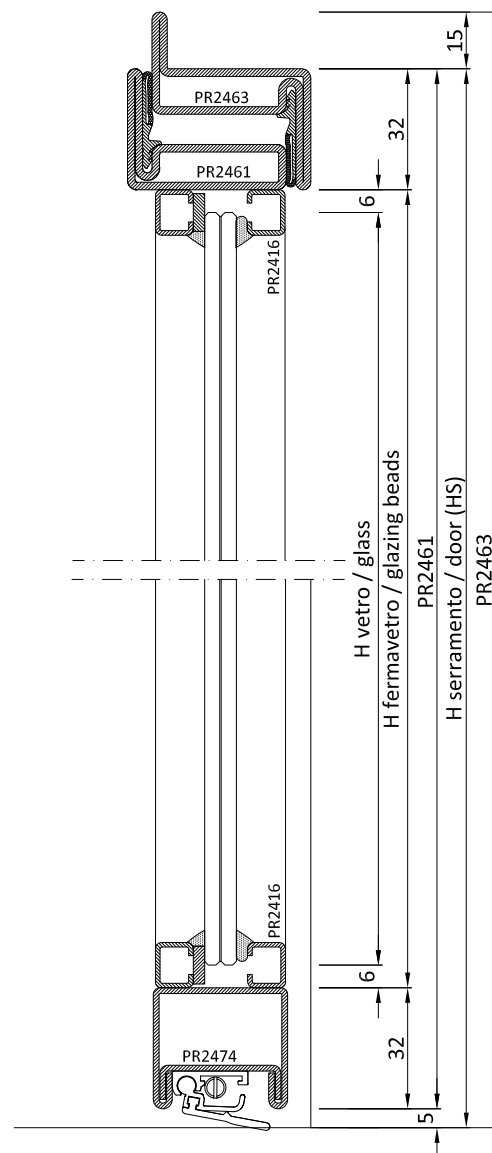


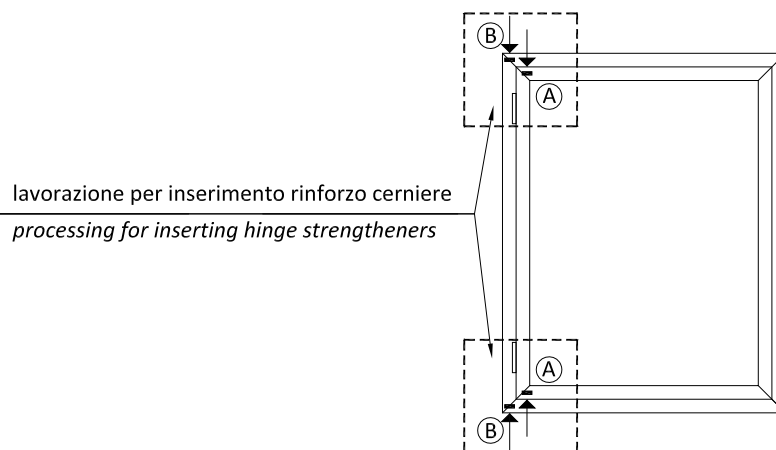
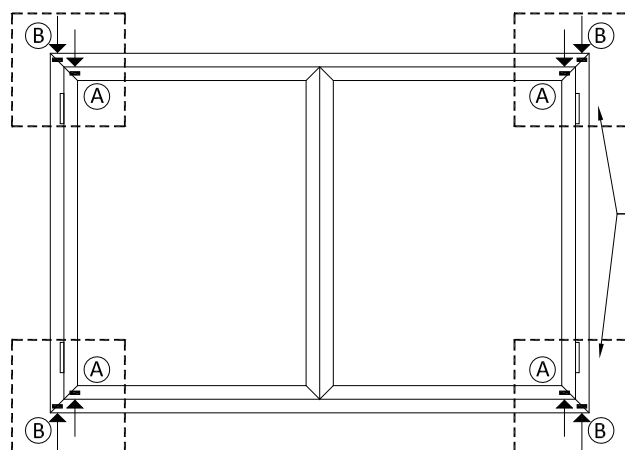
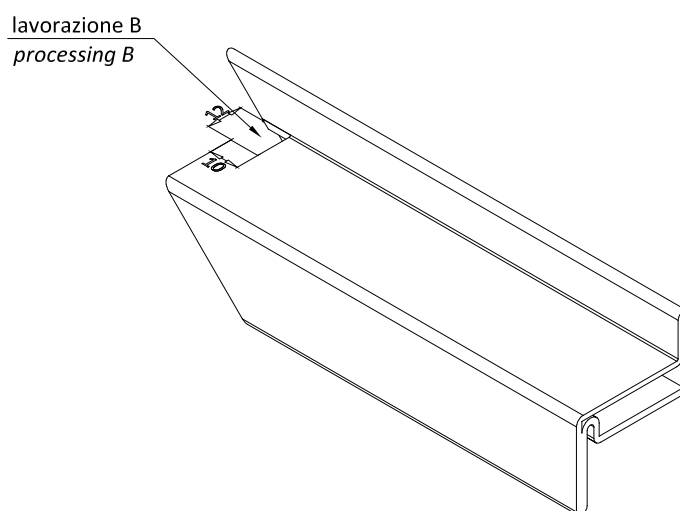
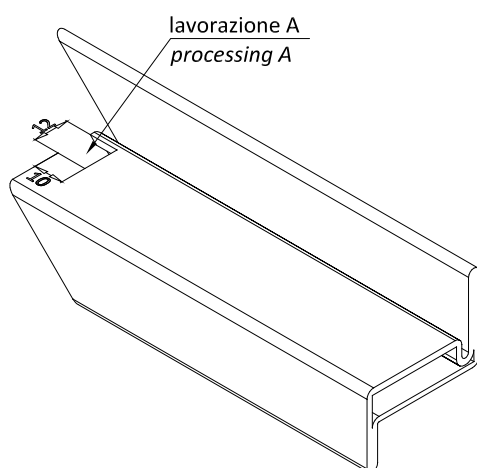
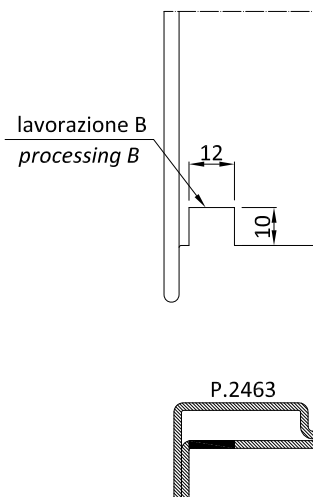
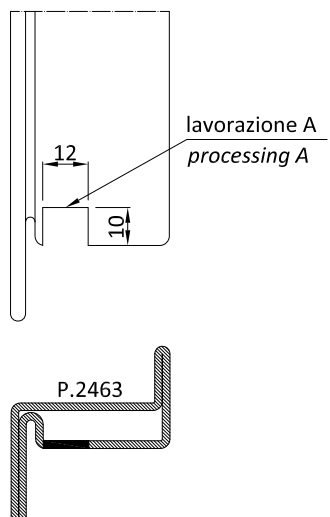
PROFILI		PROFILES			
Cod.	Descrizione	Description	n°	Dim.	Taglio Cutting
Telaio		Frame			
PR2463	Profilo a "Z" telaio	"Z" profile frame	1	LS+30	45° 45°
PR2463	Profilo a "Z" telaio	"Z" profile frame	1	HS+15	45° 90°
PR2463	Profilo a "Z" telaio	"Z" profile frame	1	HS+15	90° 45°
Anta		Leaf			
PR2461	Profilo a "L" anta	"L" profile leaf	2	LS/2+16	45° 45°
PR2461	Profilo a "L" anta	"L" profile leaf	3	HS-5	45° 90°
PR2461	Profilo a "L" anta	"L" profile leaf	1	HS-5	90° 45°
PR2474	Profilo Zoccolo	Socle profile	2	LS/2-48	90° 90°
Fermavetri		Glazing beads			
PR2416	Profilo fermavetro	Glazing bead profile	4	LS/2-48	45° 45°
PR2416	Profilo fermavetro	Glazing bead profile	4	HS-69	45° 45°
Vetri		Glass unit			
-	Vetrocamera	Insulated glass	2	LS/2-60 x HS-81	

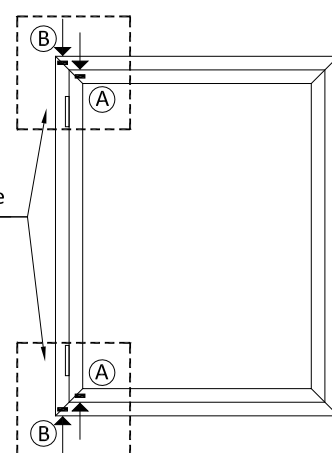
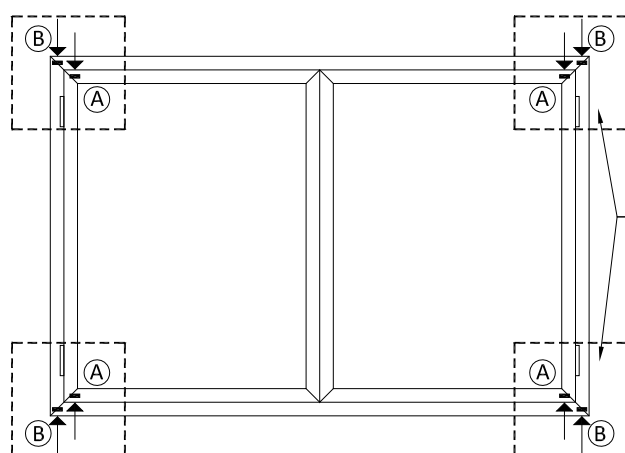
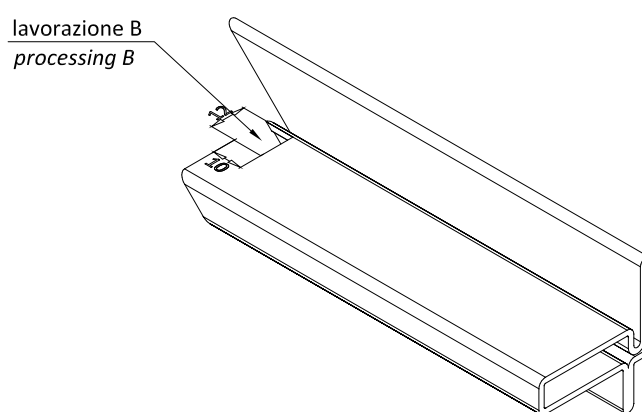
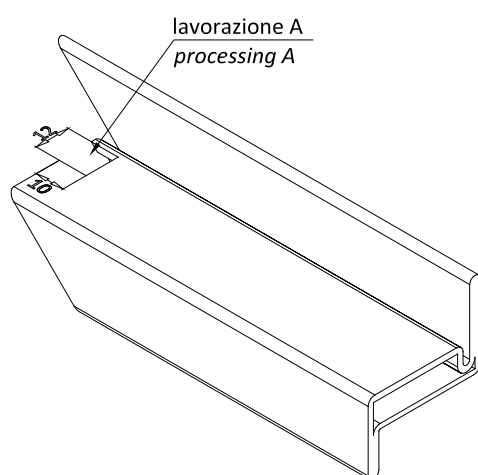
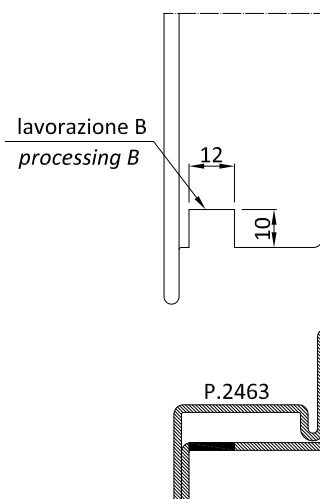
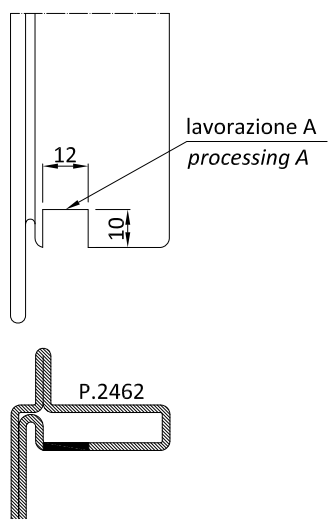


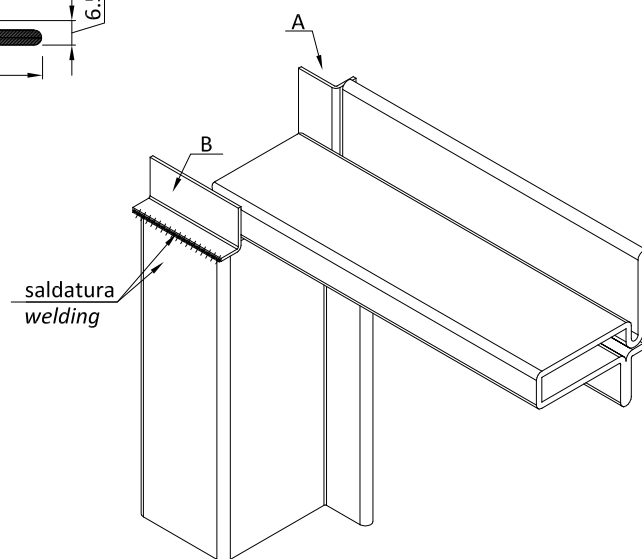
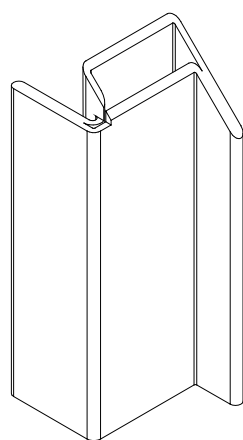
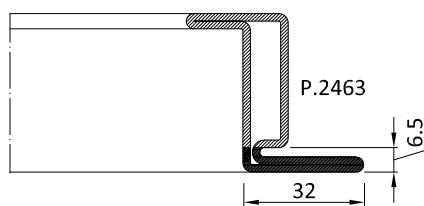
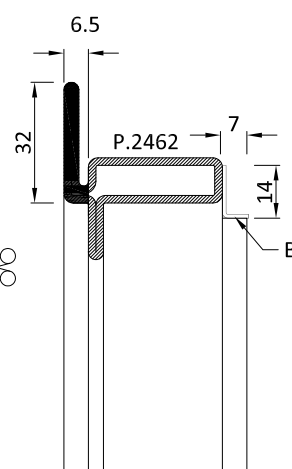
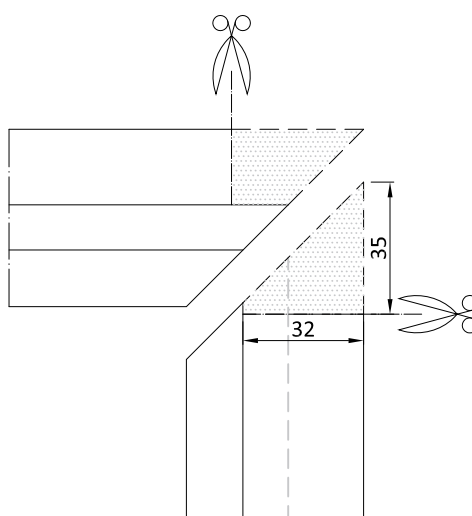
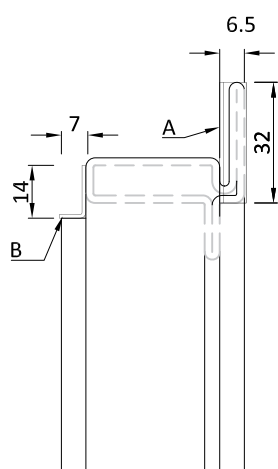
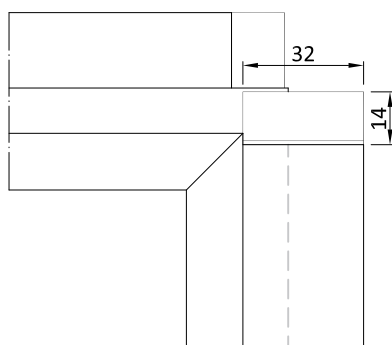
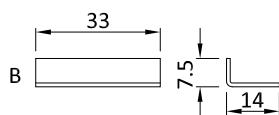
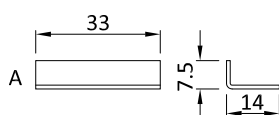
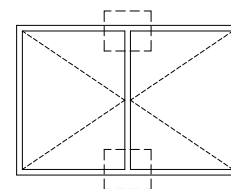
ACCESSORI		HARDWARE	
Cod.	Descrizione	Description	n°
AC5023	Clips fissaggio fermavetri	Clips to secure glazing beads	Var.
AC....	Catenaccio 2^ anta	Second leaf bolt	2
AC....	Cerniere	Hinges	Var.
AC2436..	Guarnizione automatica	Automatic bottom seal	2
AC2653	Fondino per 2^ anta	Bottom plate for second leaf	2
AC2493	Serratura	Lock	1
AC2498	Scatola copri serratura	Lock cover box	1
ACV95..	Maniglia "Vitruvio"	"Vitruvio" handle	1
ACV040	Quadro maniglia	Handle spindle bar	1
ACV964..	Bocchetta copri cilindro	Euro cylinder escutcheon plate	2

GUARNIZIONI		GASKETS		
Cod.	Descrizione	Description	n°	Dim.
GE2543TT	Guarnizione esterna di battuta	Rebating gasket	1	2xLS+6HS
GU2416	Piattina adesiva fondo giunto	Adhesive shim for joint	1	2xLS+4xHS
GP0095	Guarnizione interna vetro	Internal weather strip	1	2xLS+4xHS

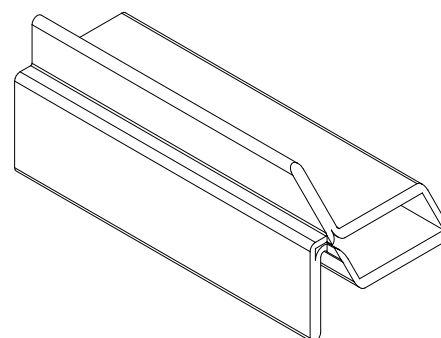
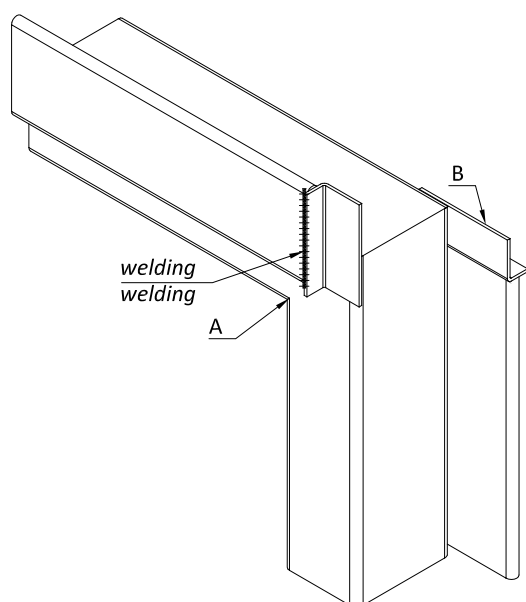
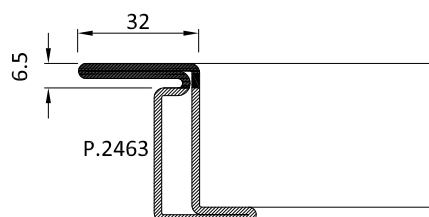
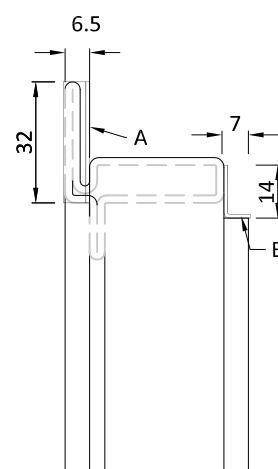
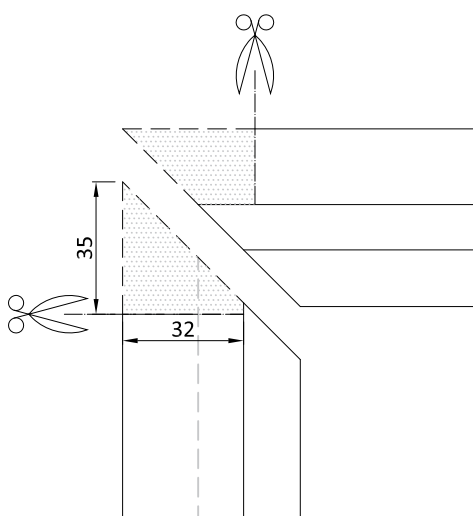
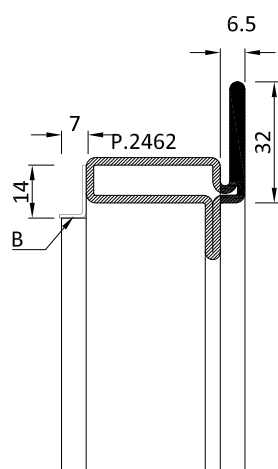
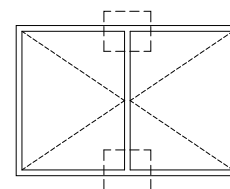
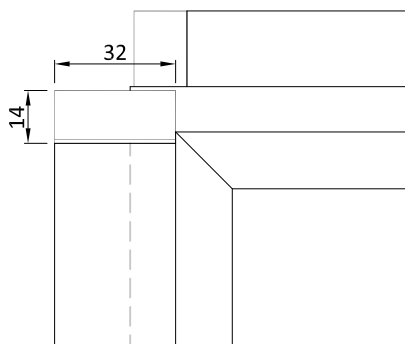
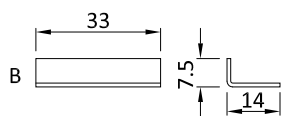
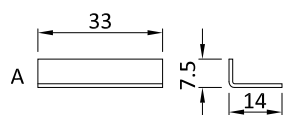




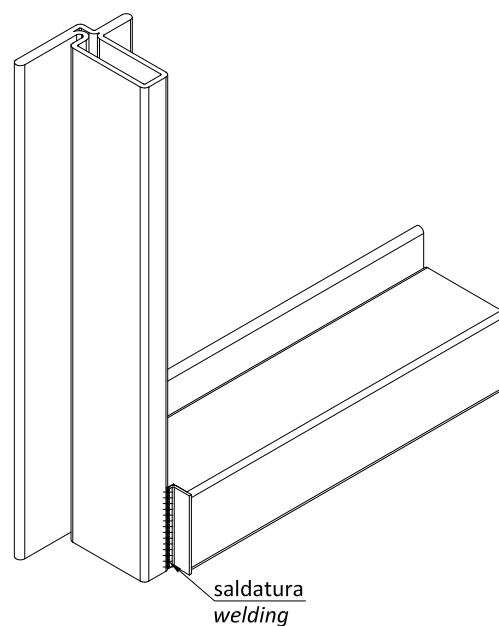
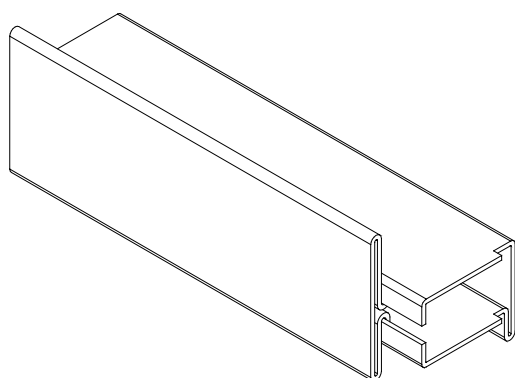
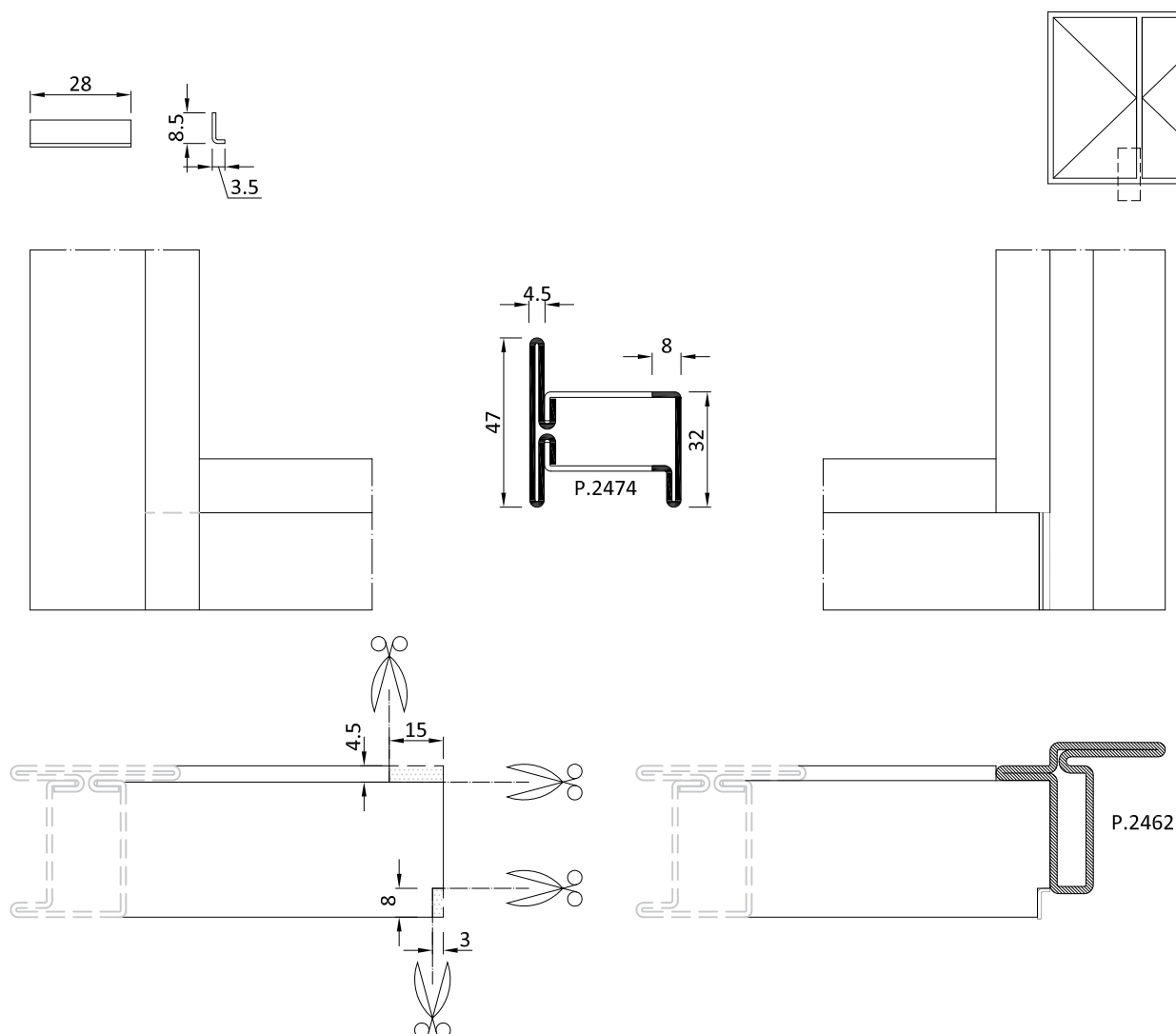




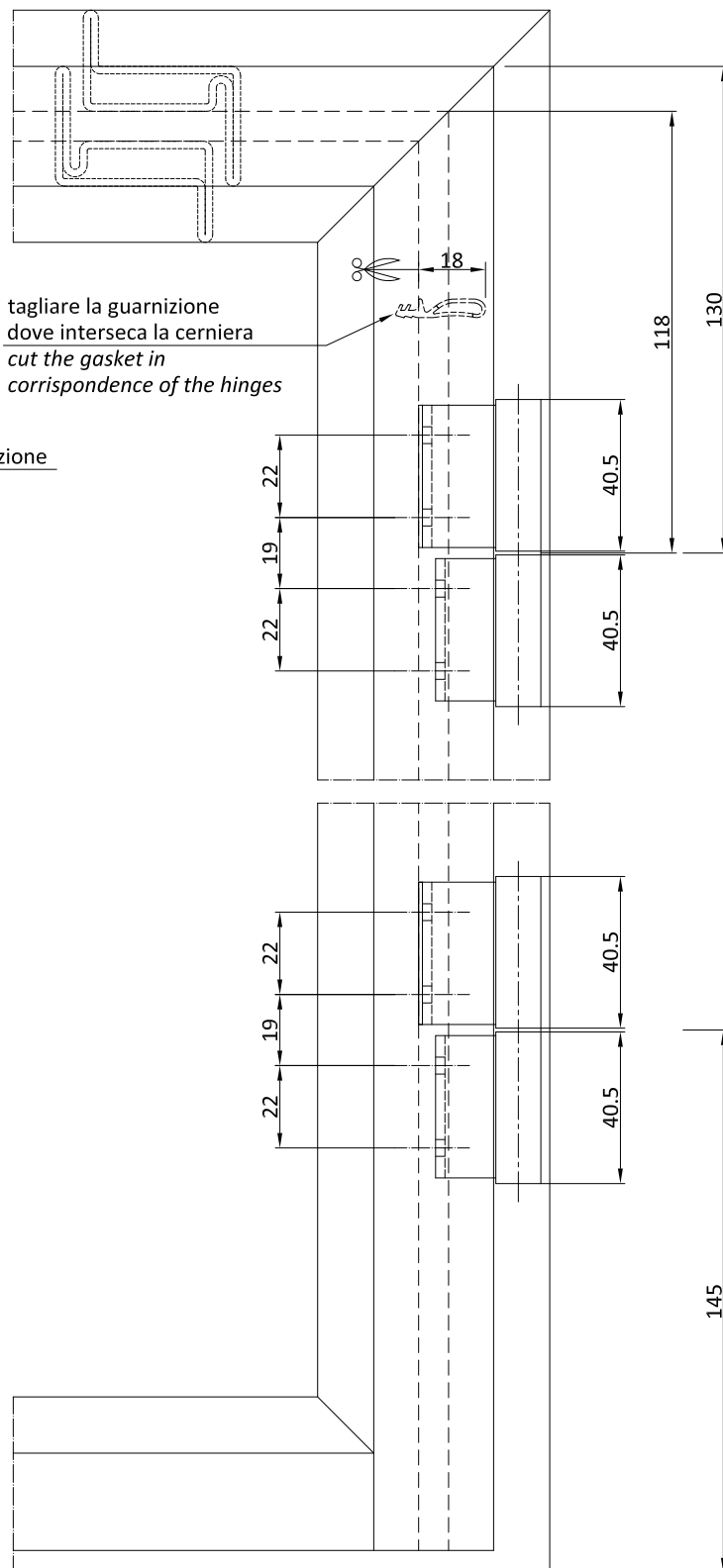
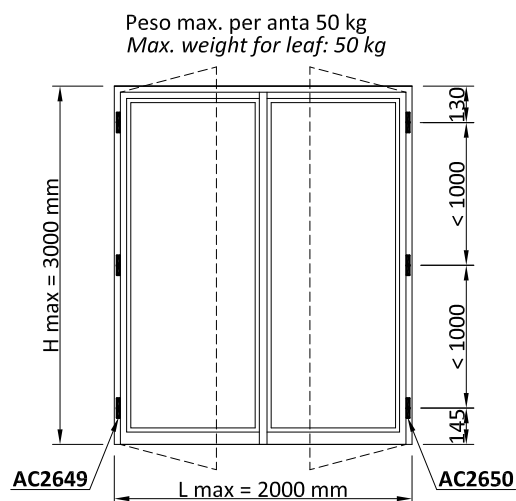
Nota: i fondini sono forniti di dimensioni maggiori da rifilare dopo la saldatura
Note: the fitting are provided larger by trimming after welding



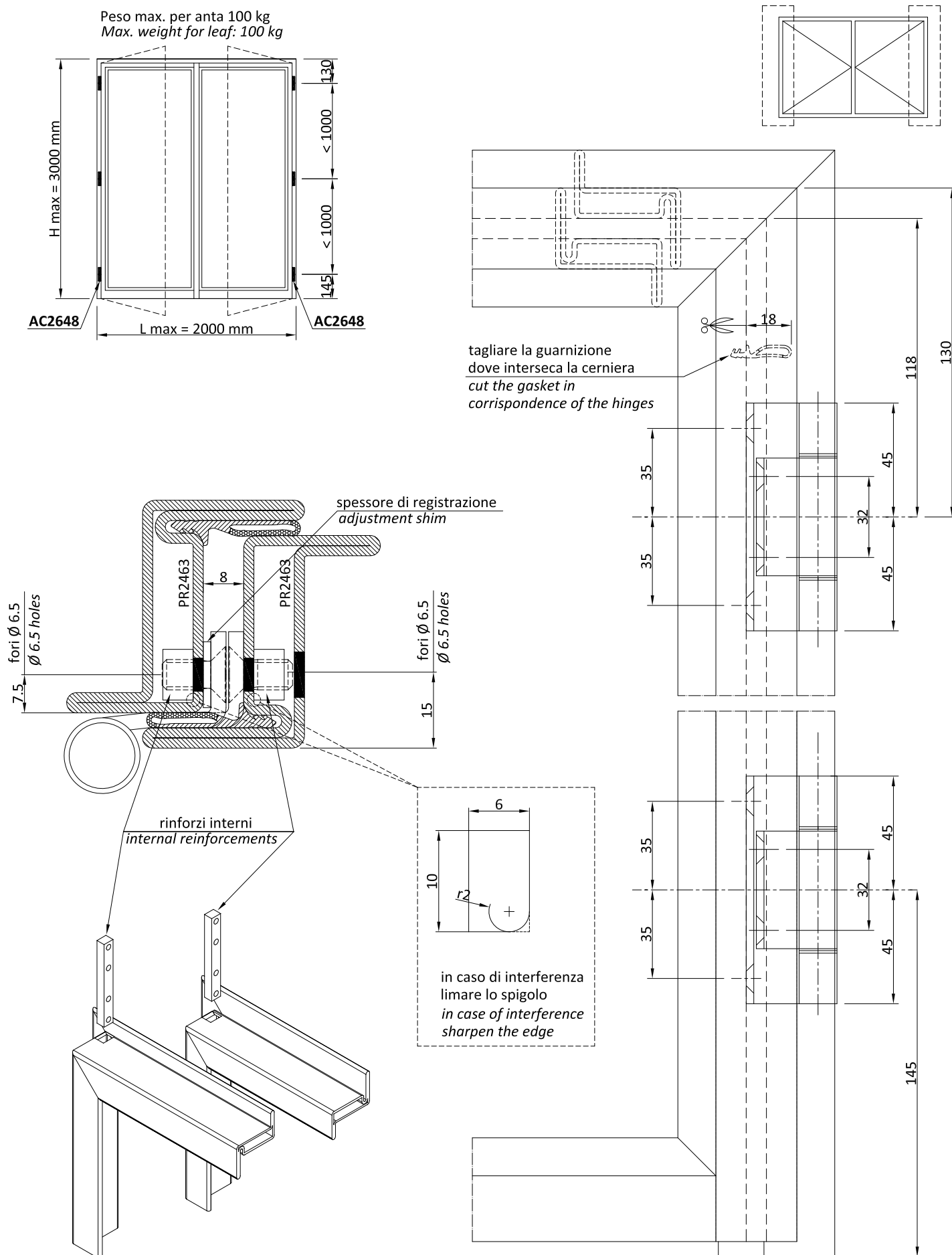
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Note: the fitting are provided larger by trimming after welding



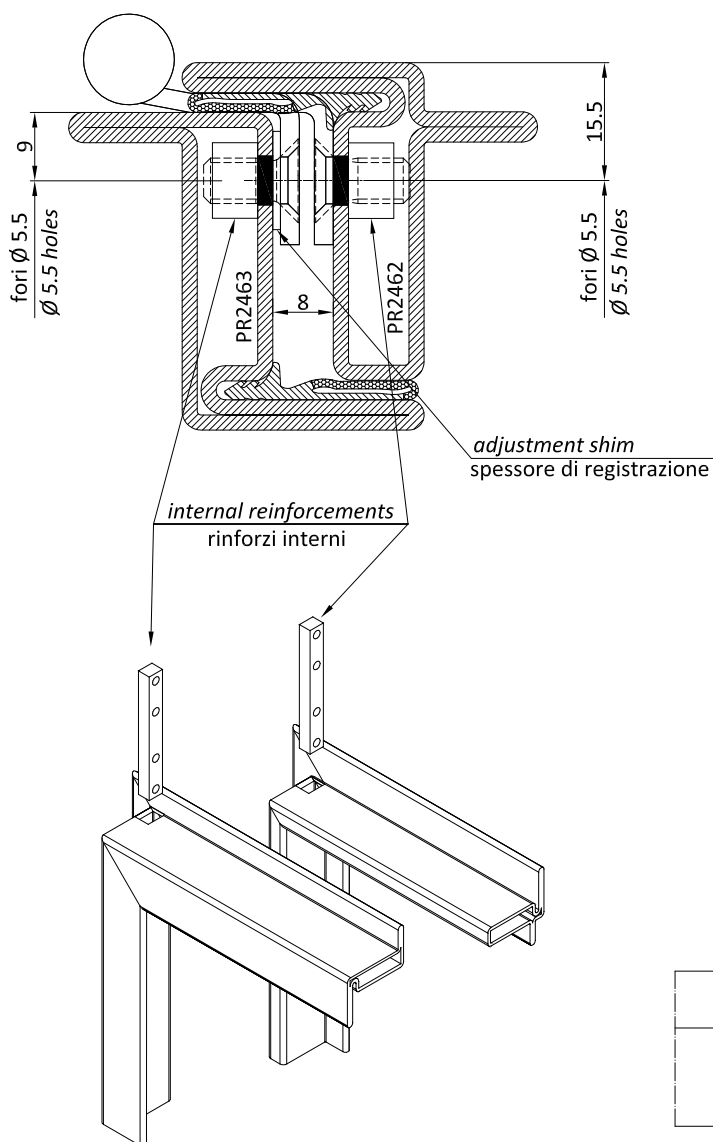
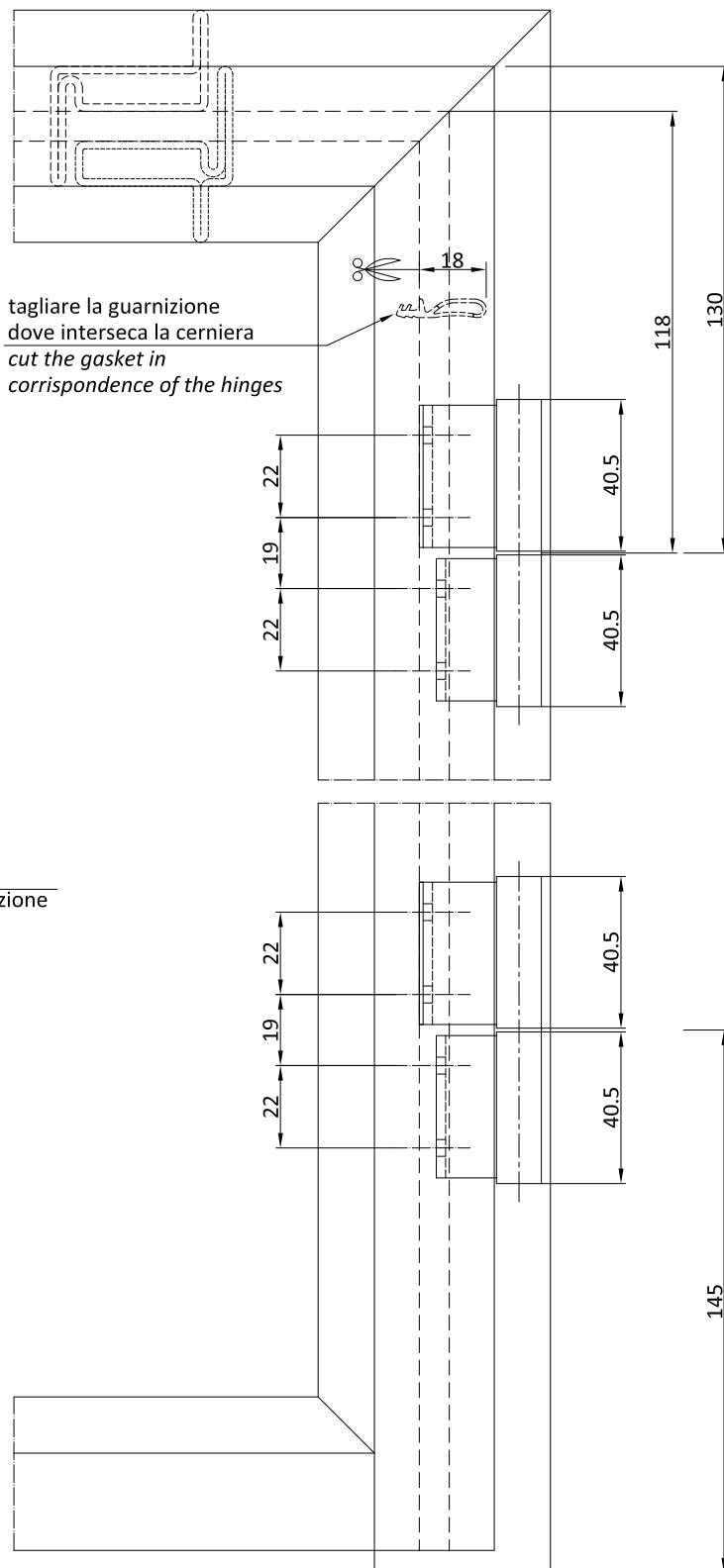
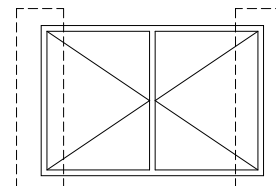
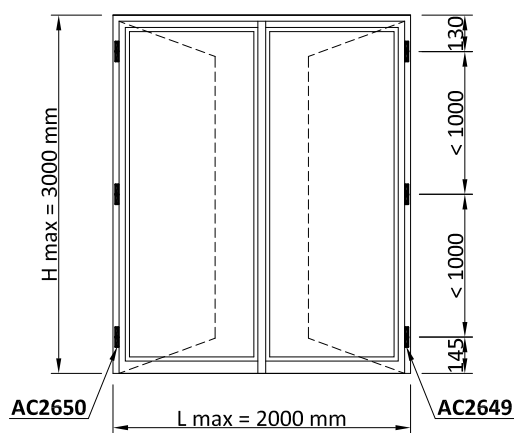
Nota: i fondini sono forniti di dimensioni maggiori da rifilare dopo la saldatura
 Note: the fittings are provided larger by trimming after welding



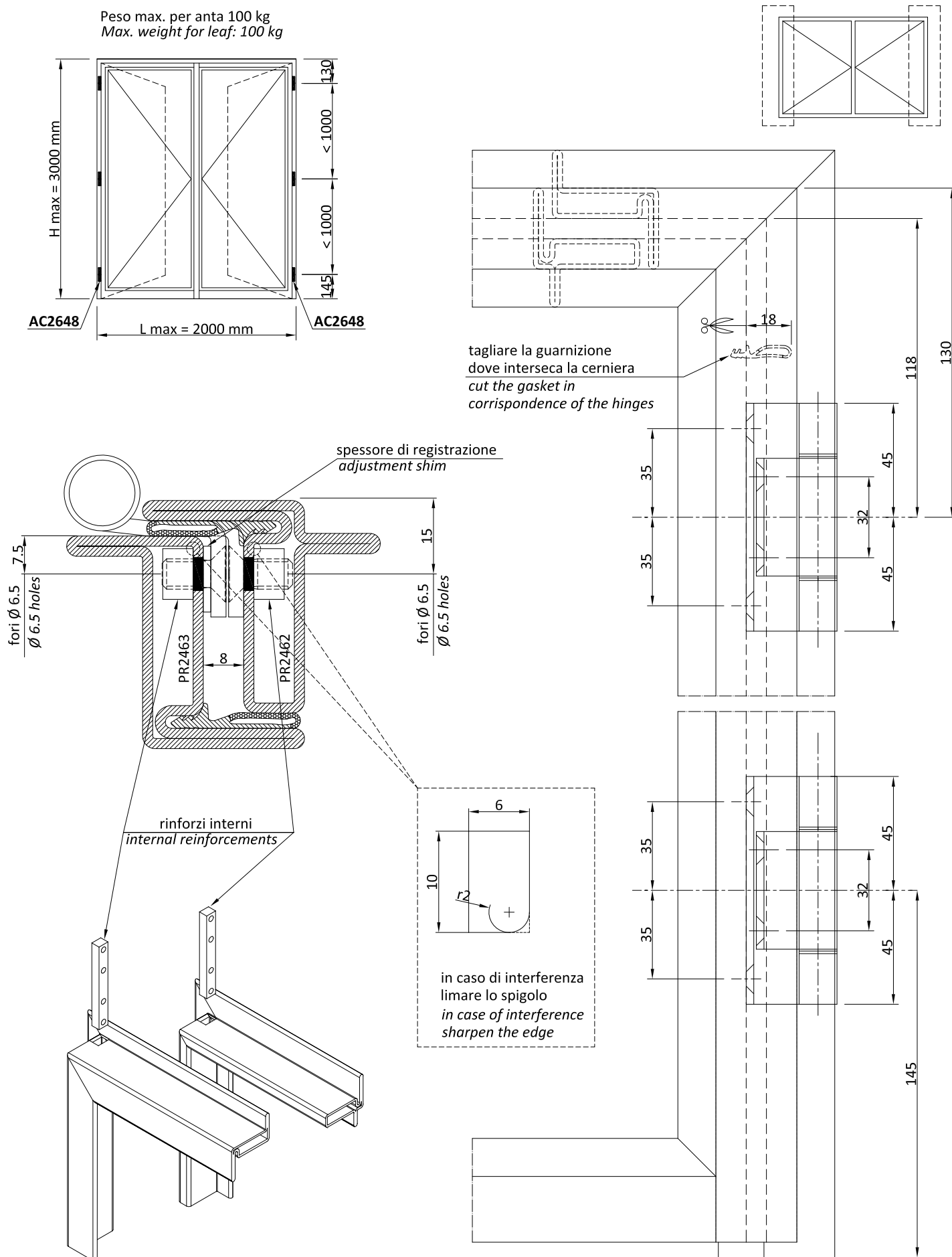
Per l'applicazione delle cerniere AC2649/AC2650 utilizzare maschera AT2629
For the installation of hinges AC2649/AC2650 please use the jig AT2629

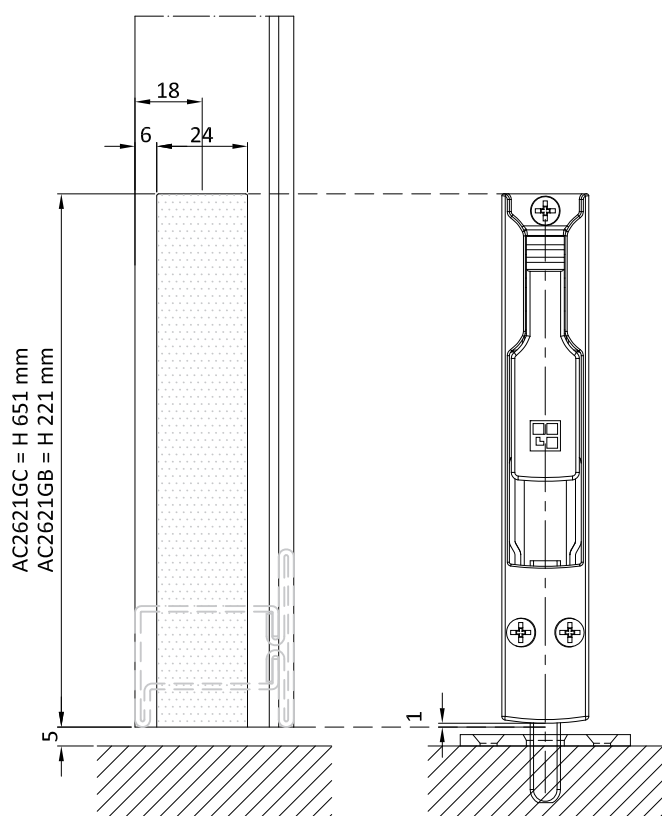
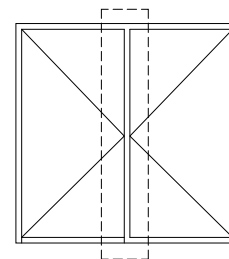
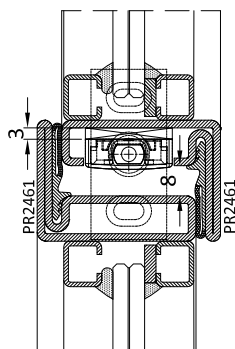
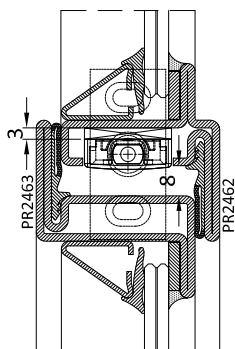
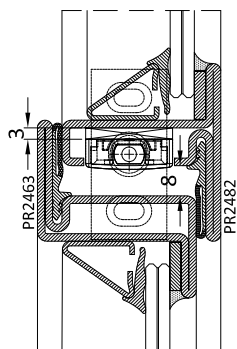
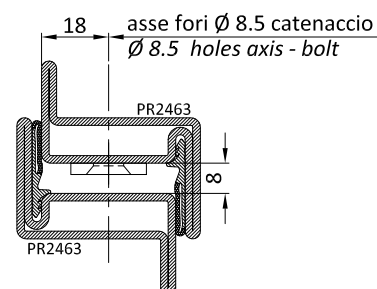
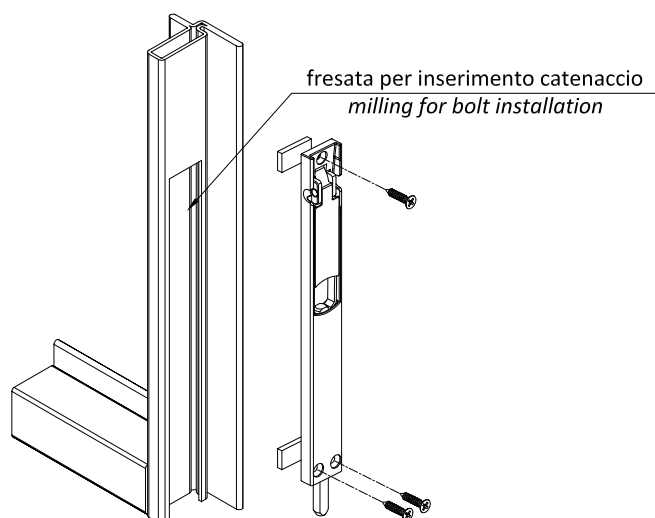
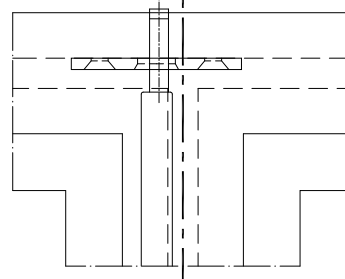
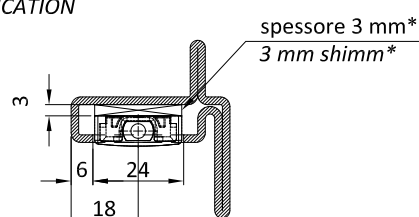


Peso max. per anta 50 kg
Max. weight for leaf: 50 kg

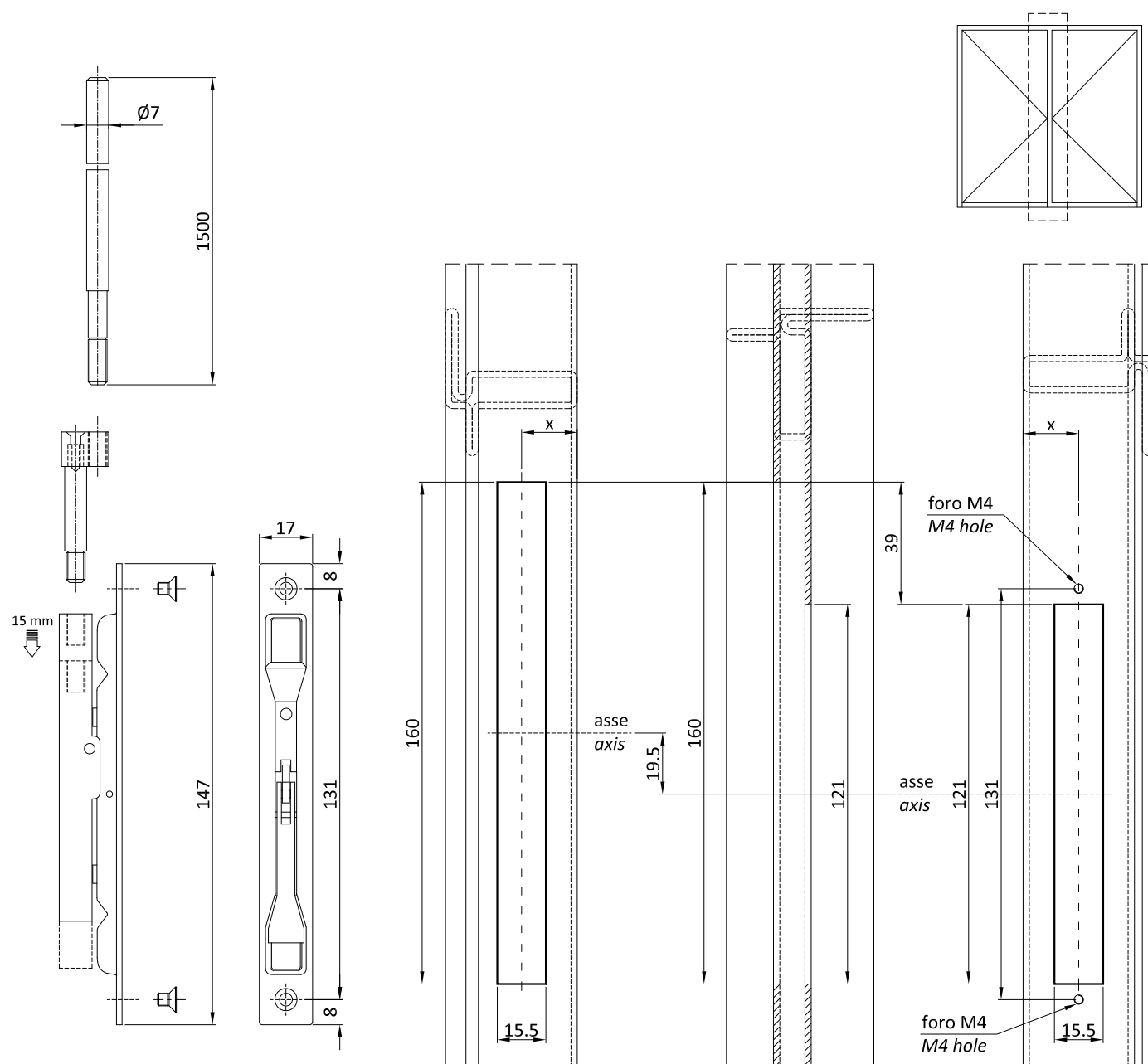


Per l'applicazione delle cerniere AC2649/AC2650 utilizzare maschera AT2629
For the installation of hinges AC2649/AC2650 please use the jig AT2629

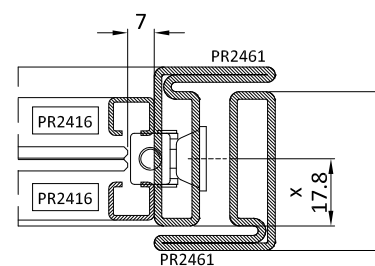
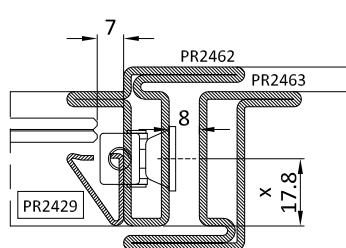
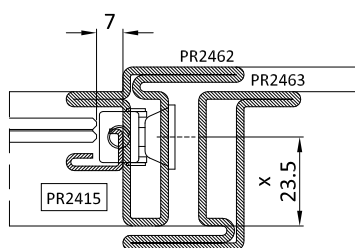


NODO SUPERIORE
UPPER SECTIONasse fori $\varnothing 8.5$ catenaccio
 $\varnothing 8.5$ holes axis - boltAPPLICAZIONE "TIPO"
TYPICAL APPLICATION

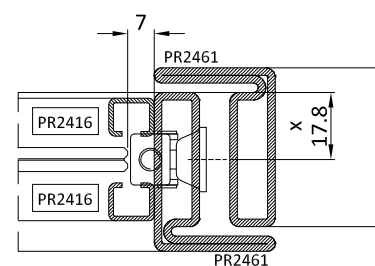
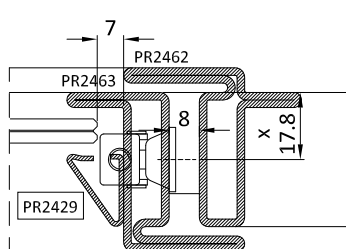
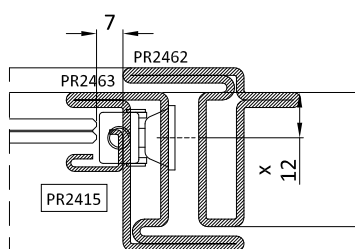
* spessore 3 mm non fornito | 3 mm shim not supplied

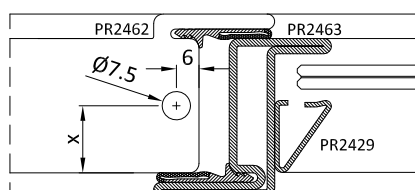
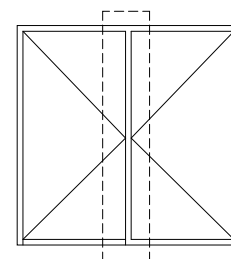
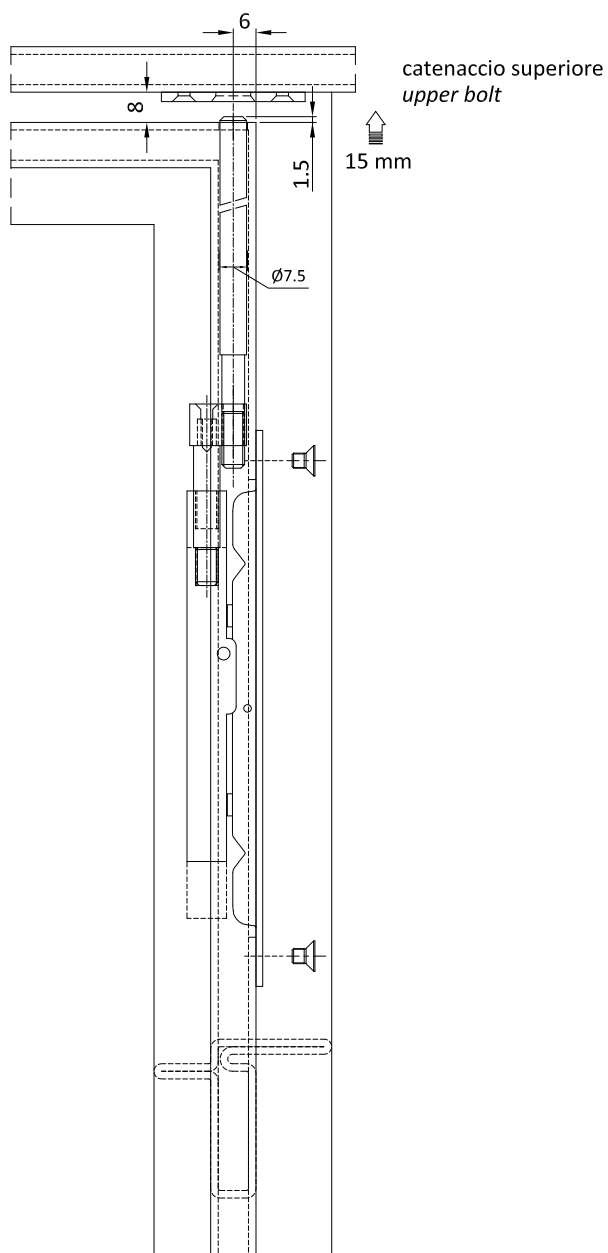
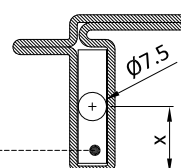
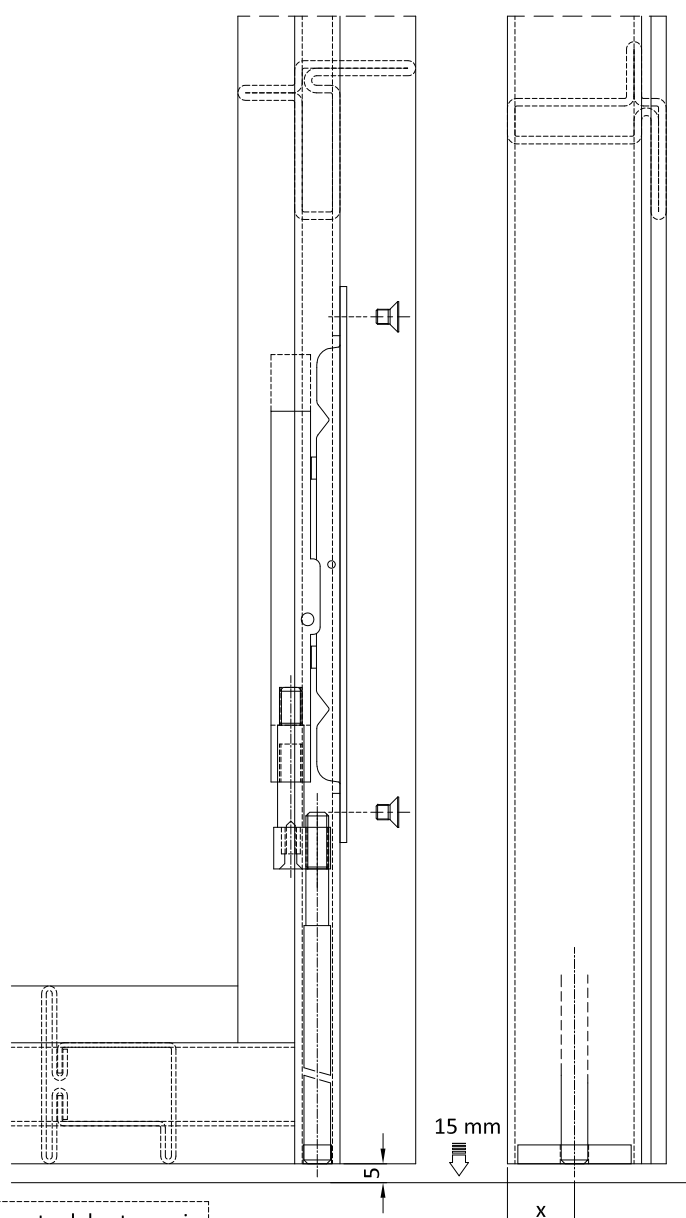


apertura interna
inward opening



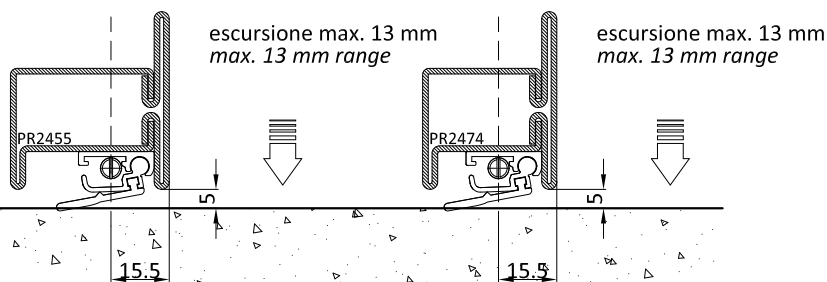
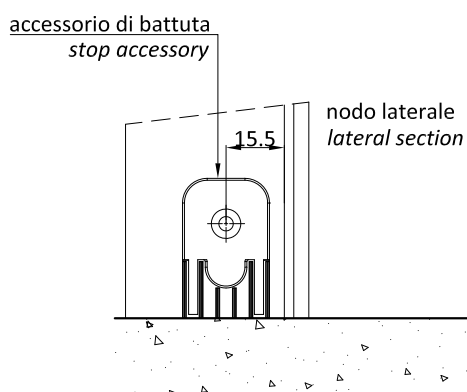
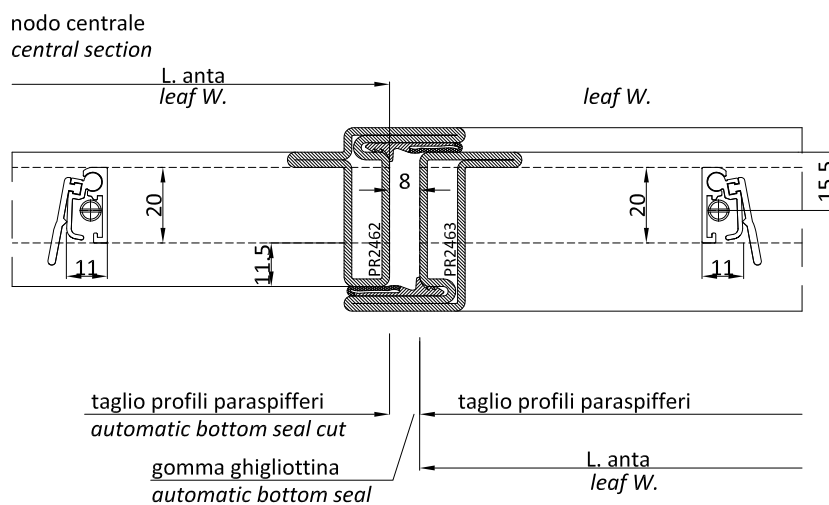
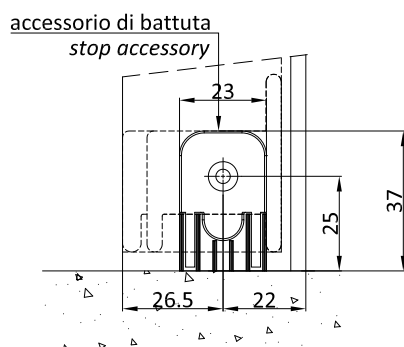
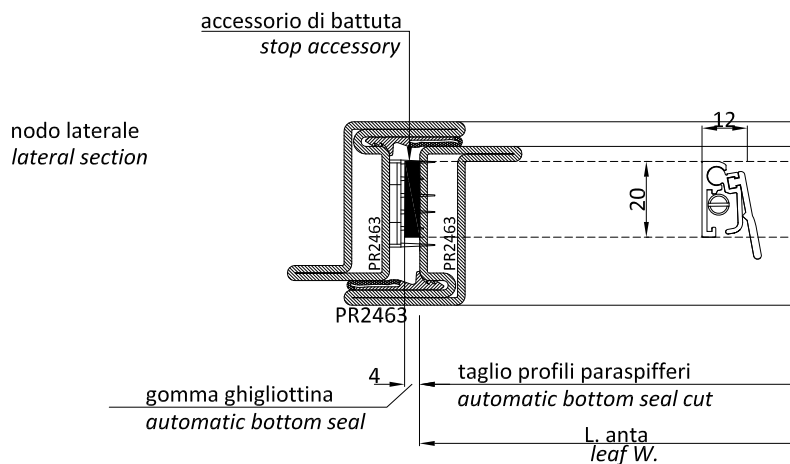
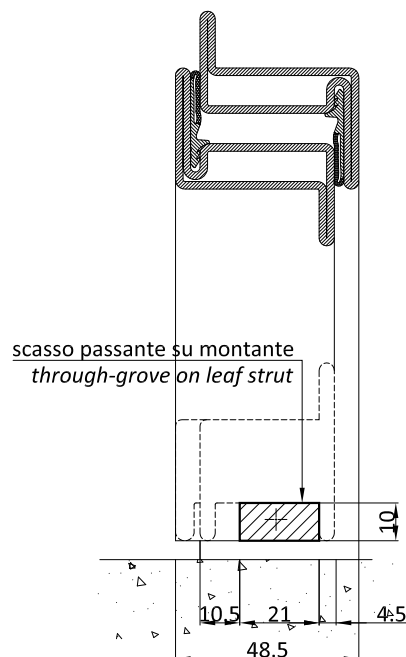
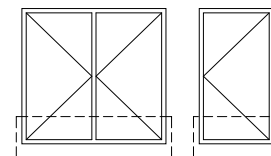
apertura esterna
outward opening



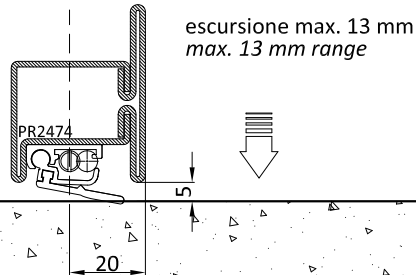
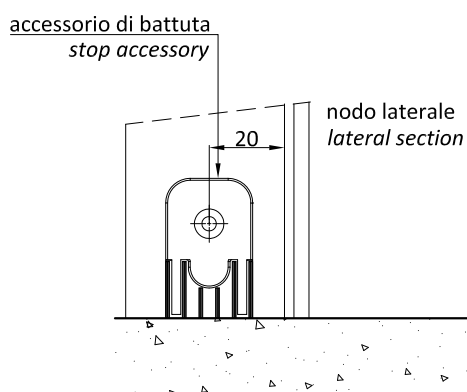
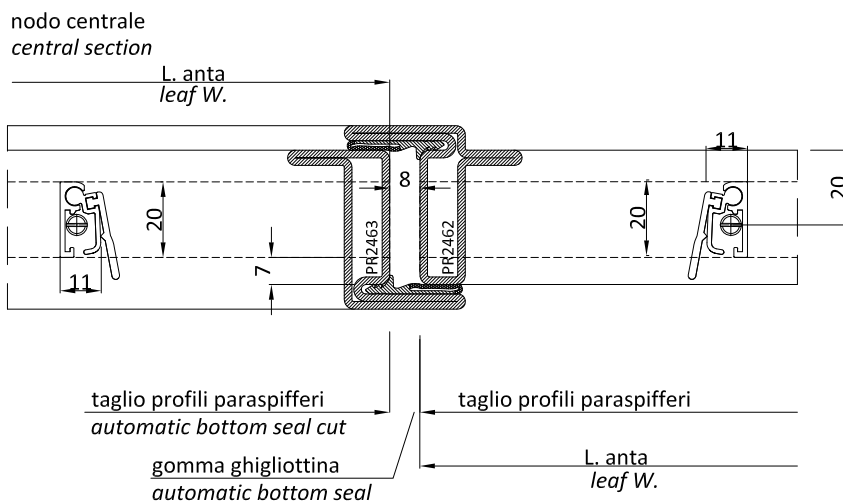
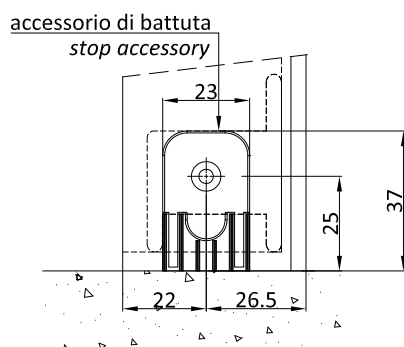
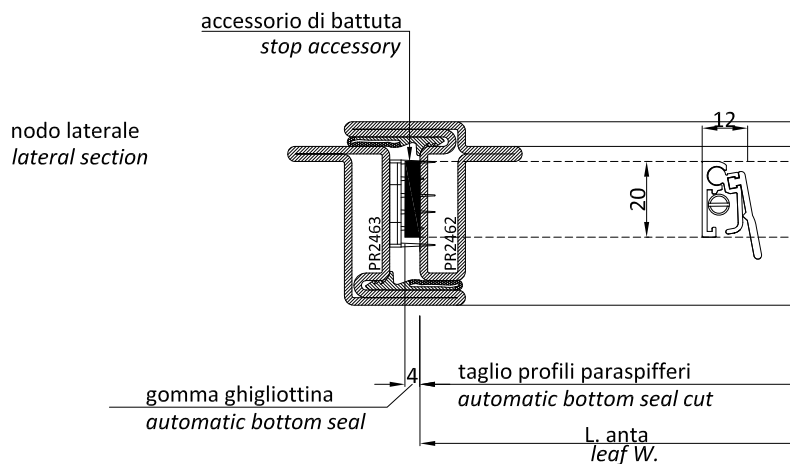
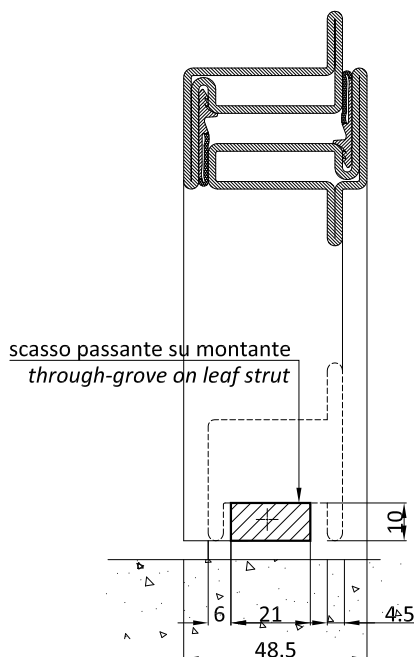
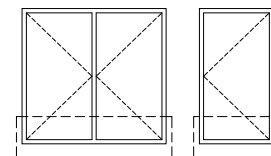
catenaccio inferiore
lower bolt

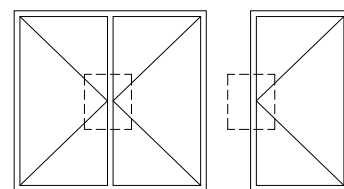
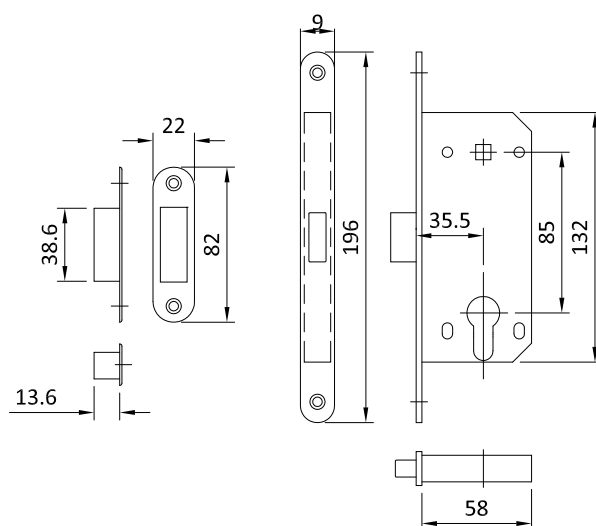
- individuare la posizione (x) corretta del foro secondo il posizionamento del catenaccio
- pre-forare Ø3 mm la piastrina in ferro
- saldarla al profilo
- allargare il foro a Ø7.5 mm
- identify the correct position (x) of the hole in according to the positioning of the bolt
- predrill Ø3 mm the steel plate
- weld it to the profile
- widen the hole to Ø7.5 mm

Cod. Cod.	lunghezza guarnizione automatica automatic bottom seal lenght	lunghezza anta leaf width
AC2436/A	310 - 530 mm	366 - 586 mm
AC2436/B	440 - 830 mm	496 - 886 mm
AC2436/C	640 - 1130 mm	696 - 1186 mm

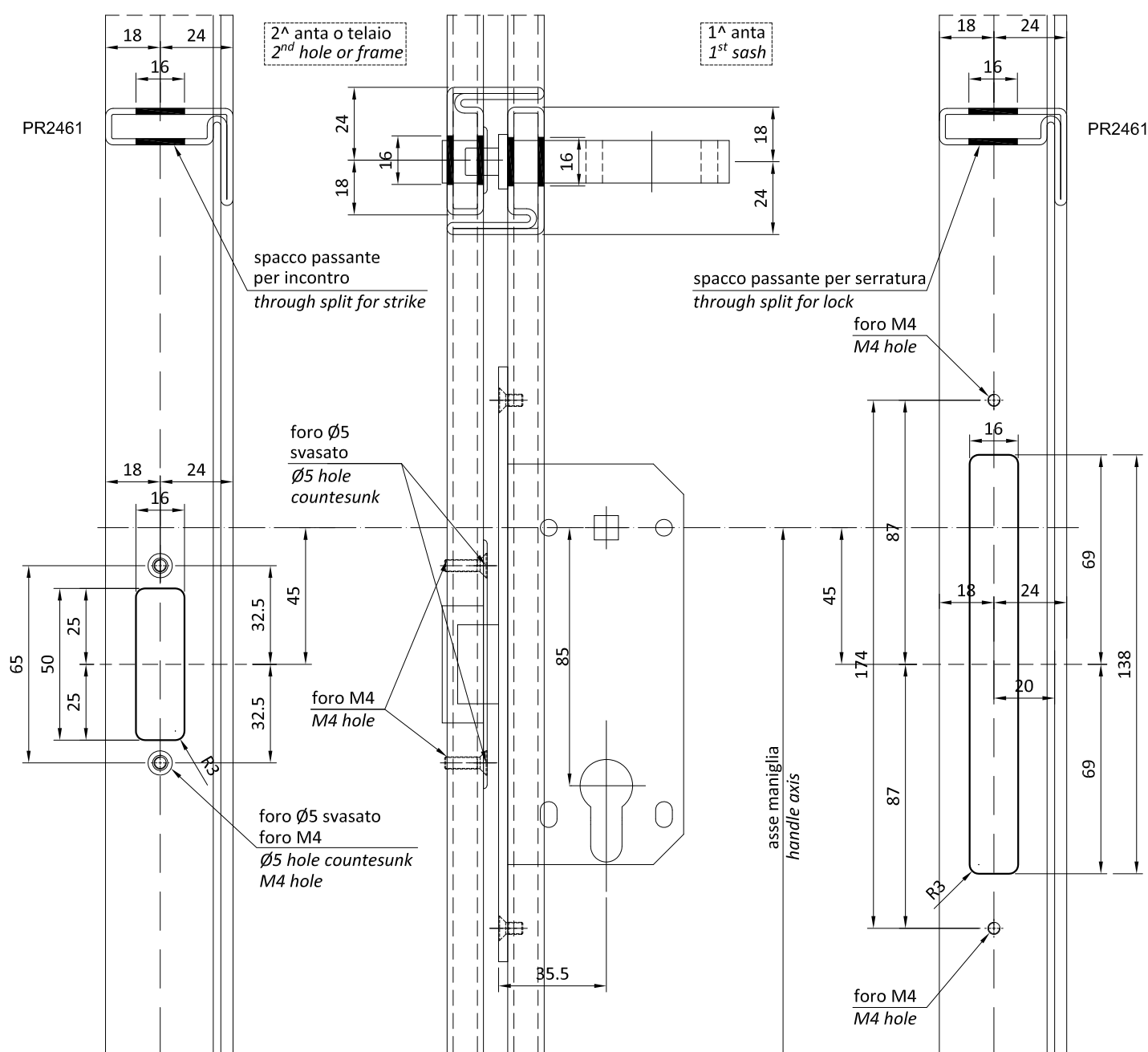


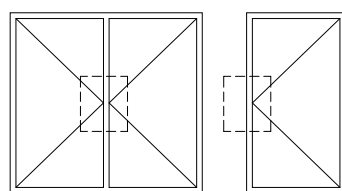
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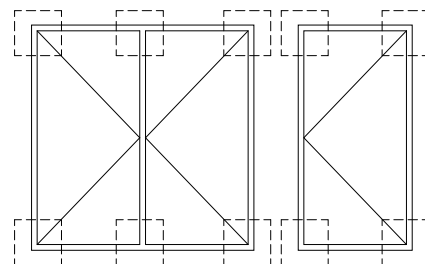
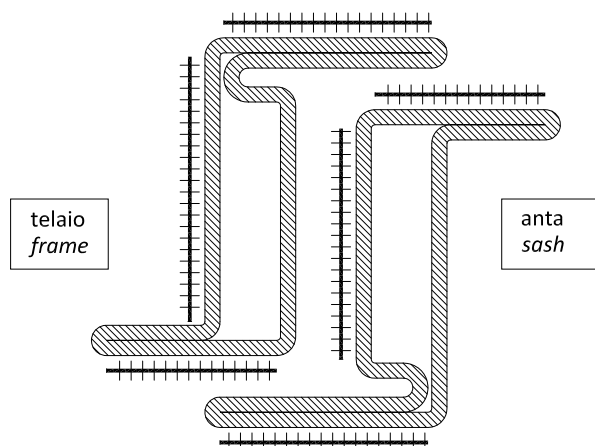


apertura interna | apertura esterna
inward opening | *outward opening*



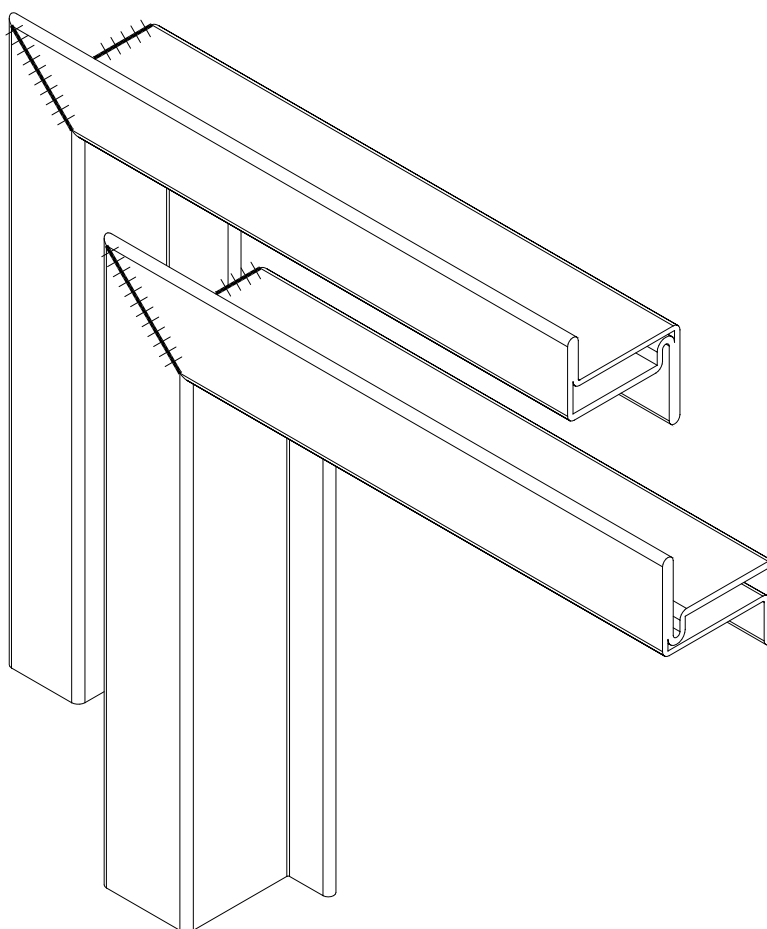


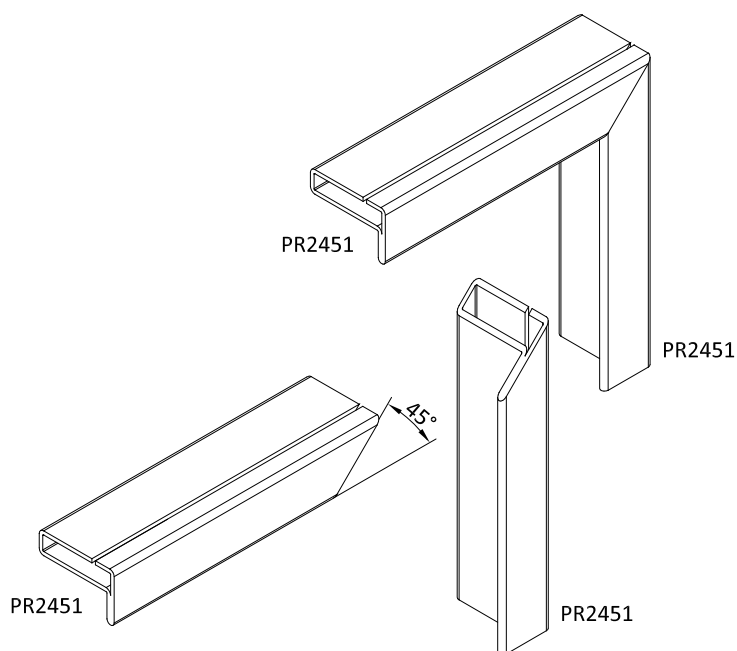
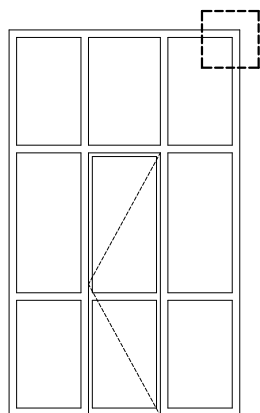




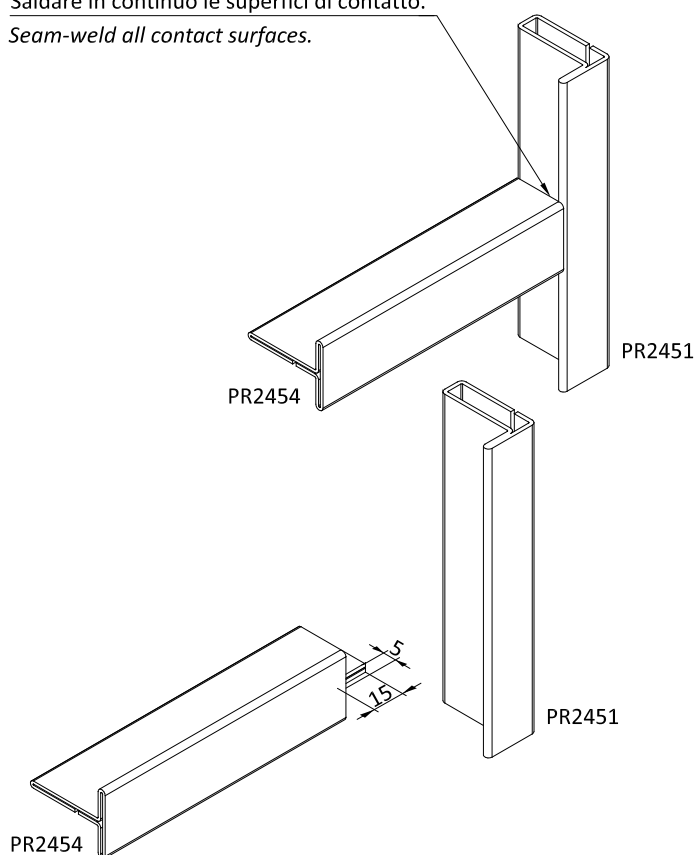
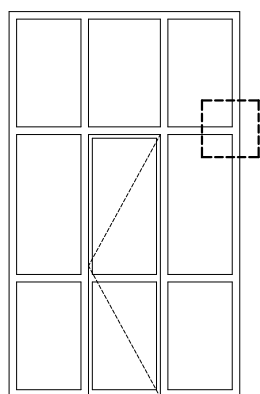
Acciaio decapato
Saldare in continuo le superfici di contatto.

Pickled steel
Seam-weld all contact surfaces.

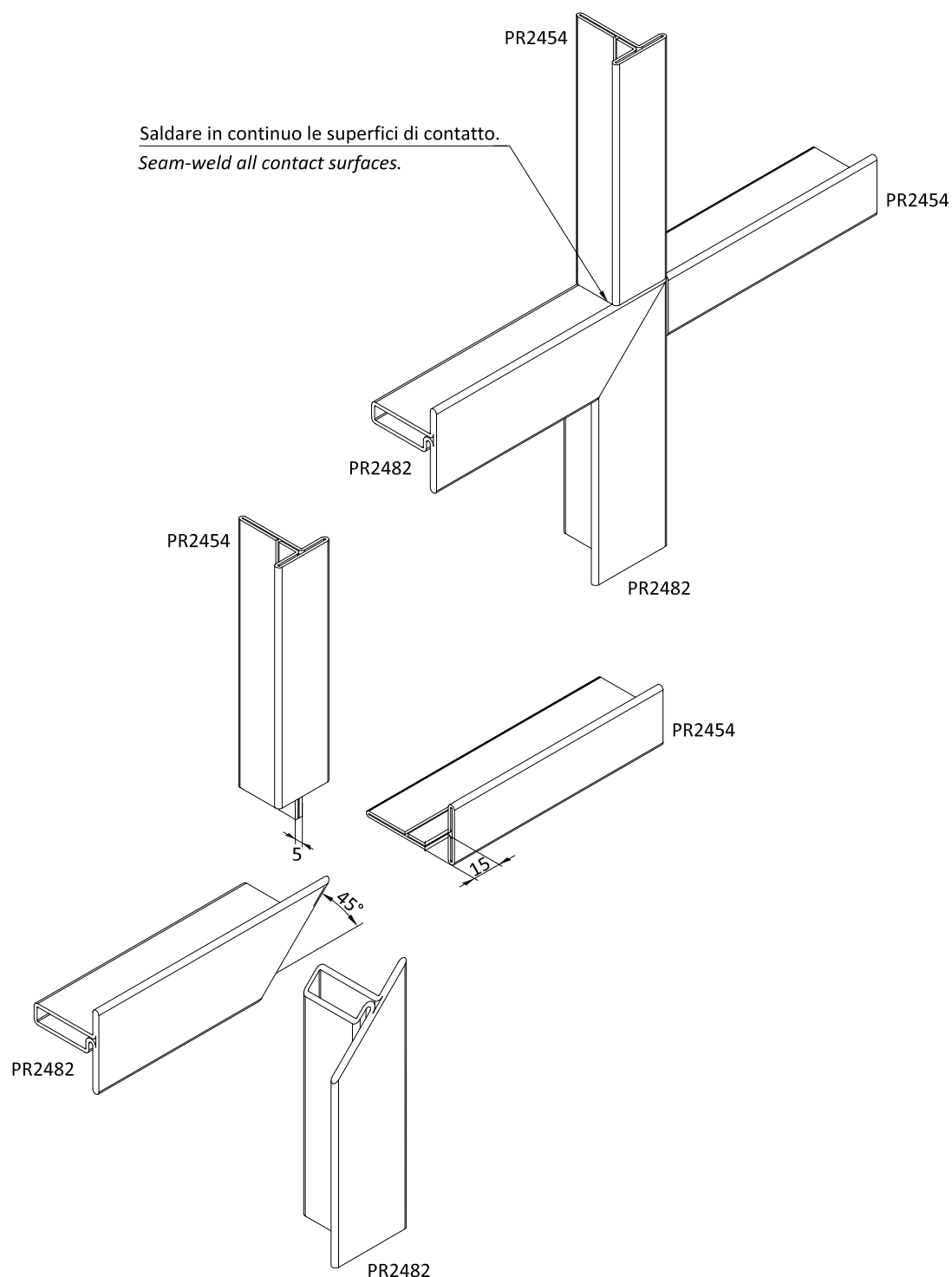
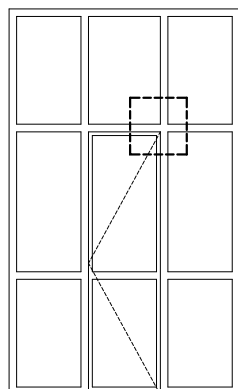




Saldare in continuo le superfici di contatto.
Seam-weld all contact surfaces.



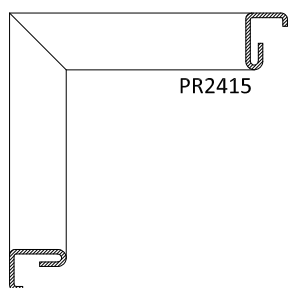
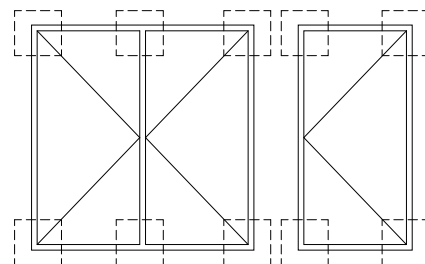
Linee guida valide per tutte le giunzioni
Same installation guide for all profiles connection



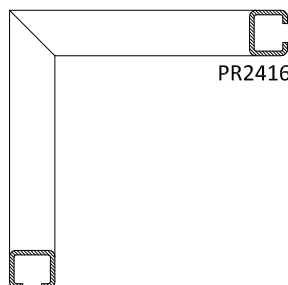
Linee guida valide per tutte le giunzioni
Same installation guide for all profiles connection

Acciaio decapato
Saldare in continuo le superfici di contatto indicate

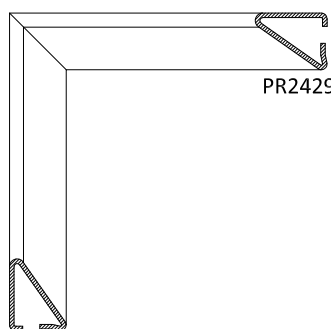
Pickled steel
Seam-weld the shown areas



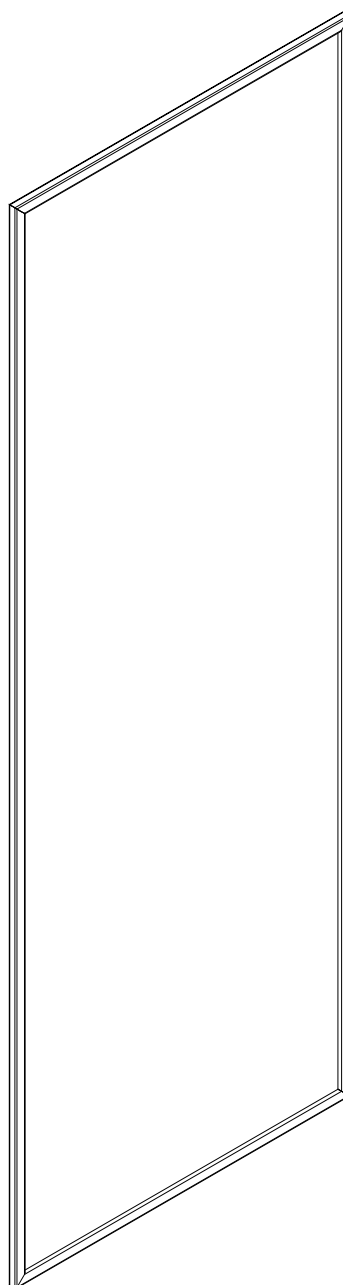
PR2415

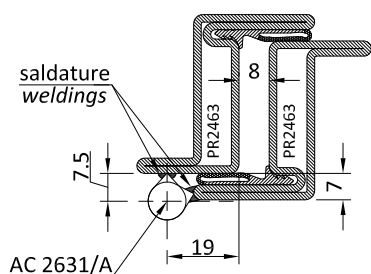
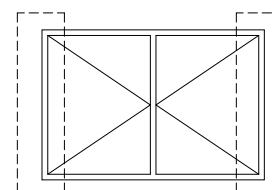
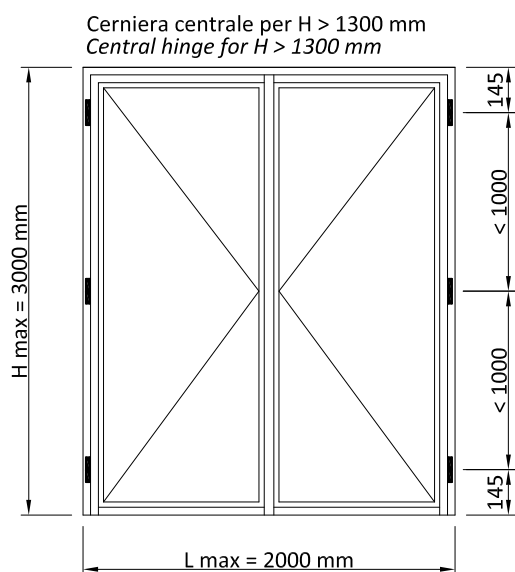


PR2416



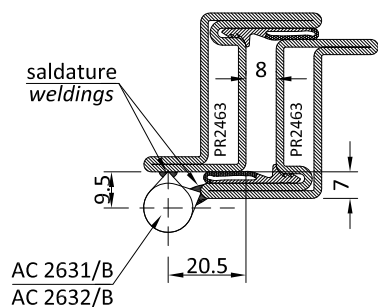
PR2429





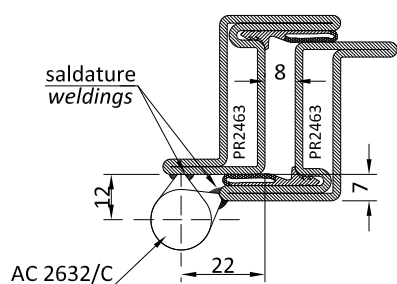
schema di fissaggio
AC2631/A non registrabile
cerniera Ø 10
peso massimo anta 40 kg

installation chart
AC2631/A non-adjustable
Ø 10 Hinge
Max leaf weight 40 kg



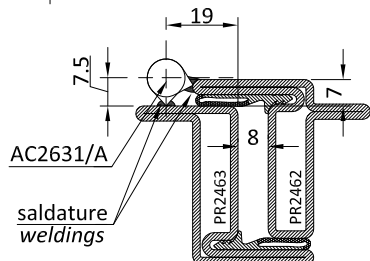
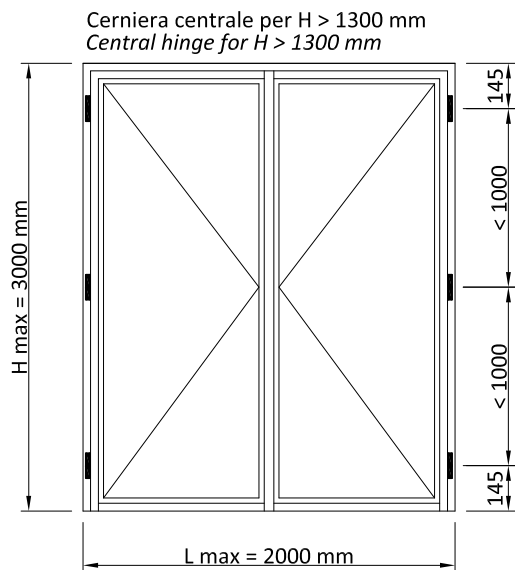
schema di fissaggio
AC2631/B non registrabile
AC2632/B registrabile in altezza
cerniera Ø 13
peso massimo anta 70 kg

installation chart
AC2631/B non-adjustable
AC2632/B adjustable in height
Ø 13 Hinge
Max leaf weight 70 kg

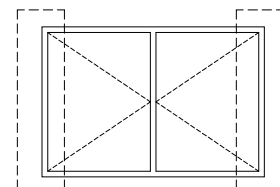


schema di fissaggio
AC2632/C registrabile in altezza
cerniera Ø 16
peso massimo anta 80 kg

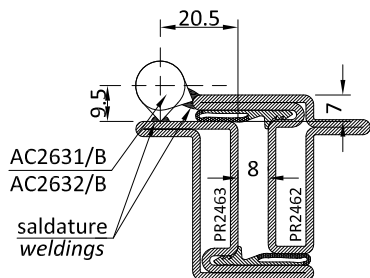
installation chart
AC2632/C adjustable in height
Ø 16 hinge
Max leaf weight 80 kg



schema di fissaggio
AC2631/A non registrabile
cerniera Ø 10
peso massimo anta 40 kg

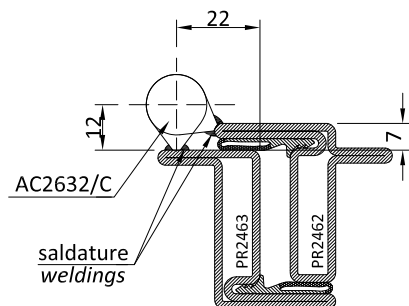


installation chart
AC2631/A non-adjustable
Ø 10 Hinge
Max leaf weight 40 kg



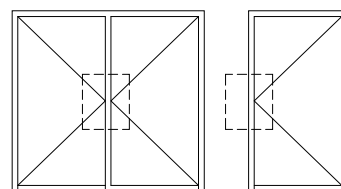
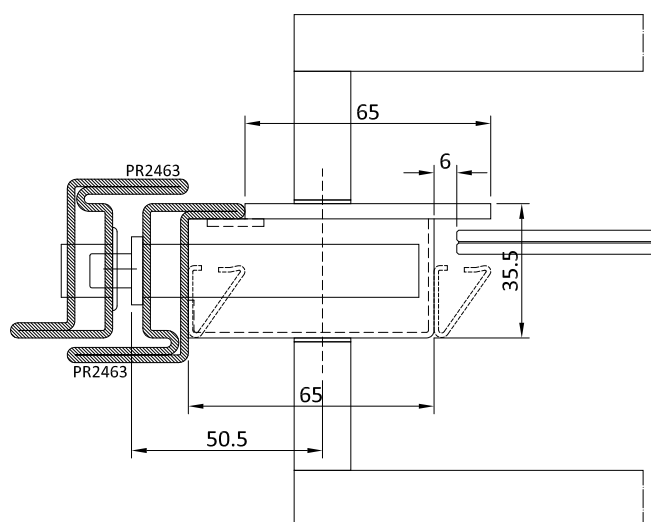
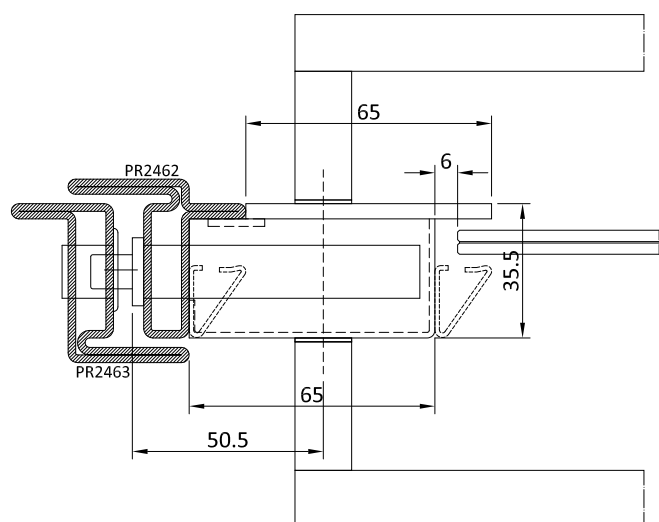
schema di fissaggio
AC2631/B non registrabile
AC2632/B registrabile in altezza
cerniera Ø 13
peso massimo anta 70 kg

installation chart
AC2631/B non-adjustable
AC2632/B adjustable in height
Ø 13 Hinge
Max leaf weight 70 kg

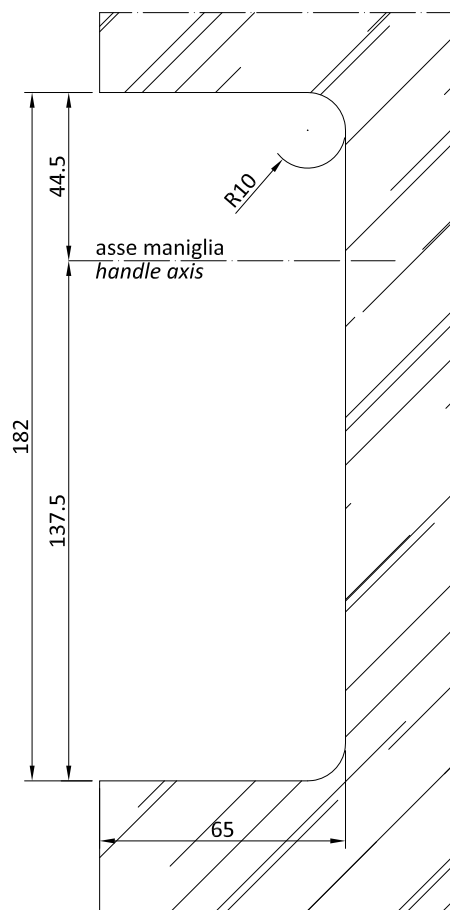
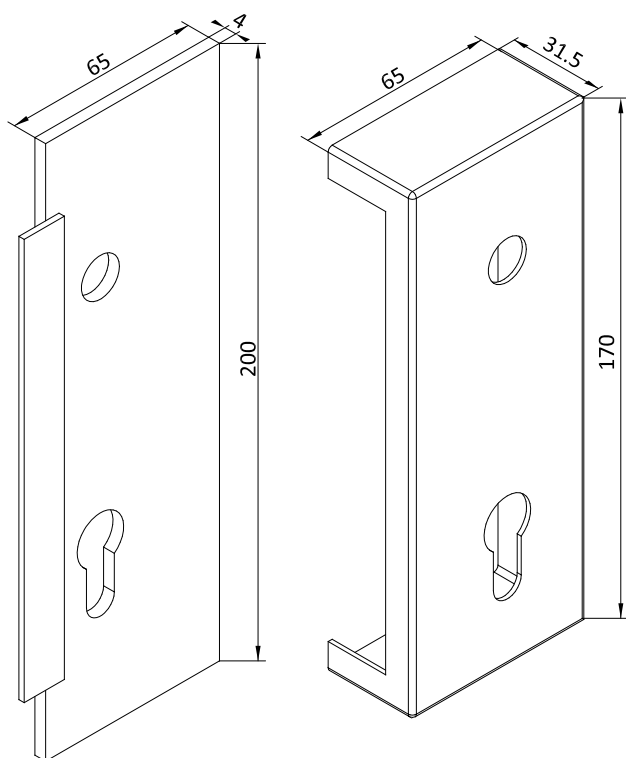


schema di fissaggio
AC2632/C registrabile in altezza
cerniera Ø 16
peso massimo anta 80 kg

installation chart
AC2632/C adjustable in height
Ø 16 hinge
Max leaf weight 80 kg



schema lavorazione vetro per inserimento serratura
glass processing scheme for lock insertion



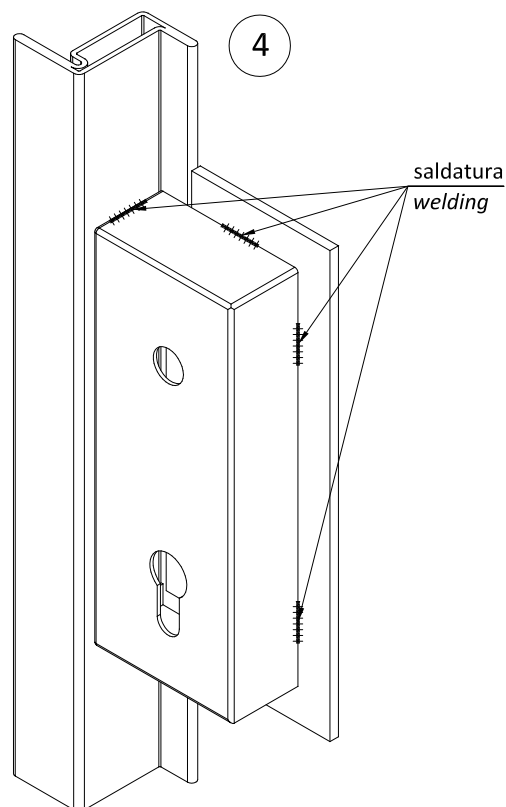
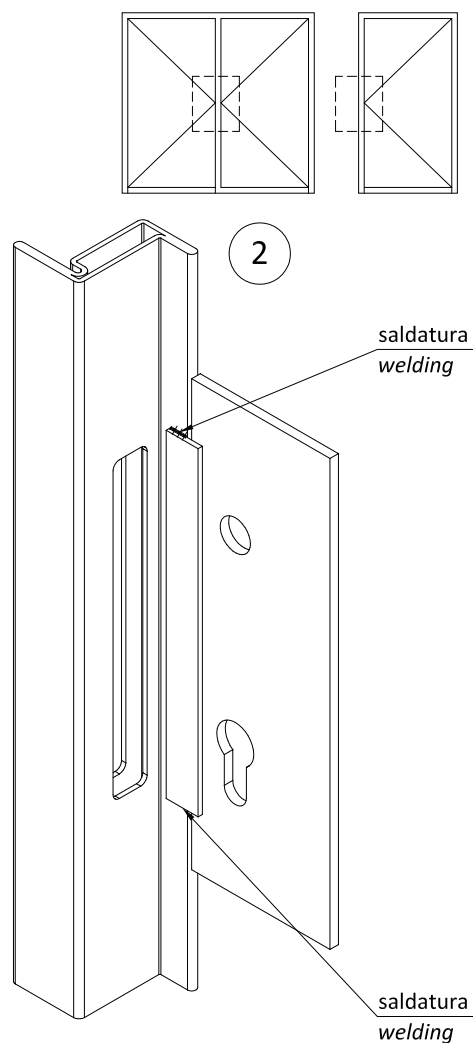
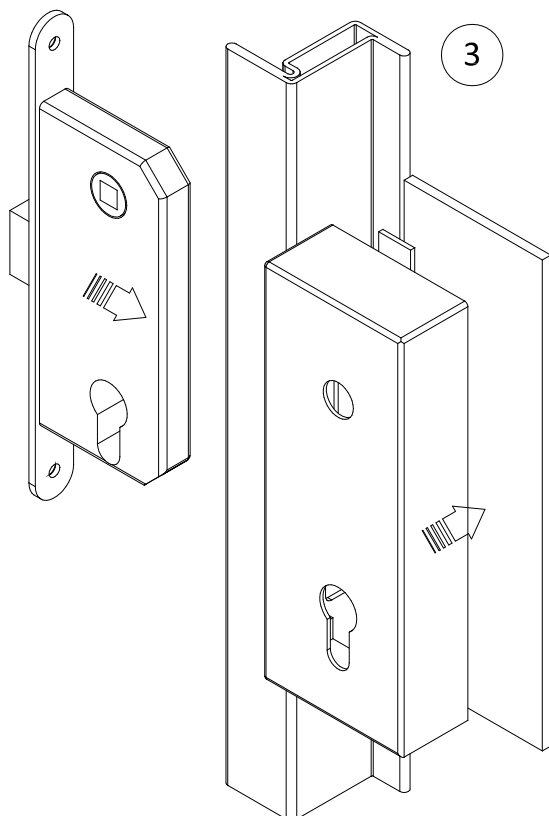
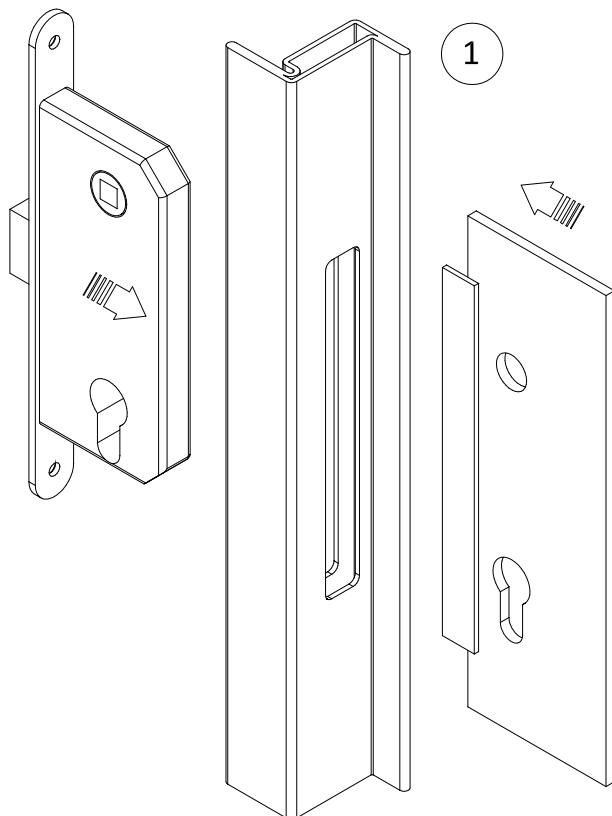
STEP

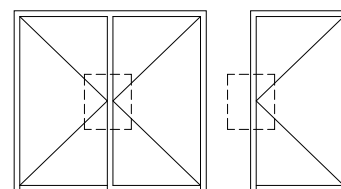
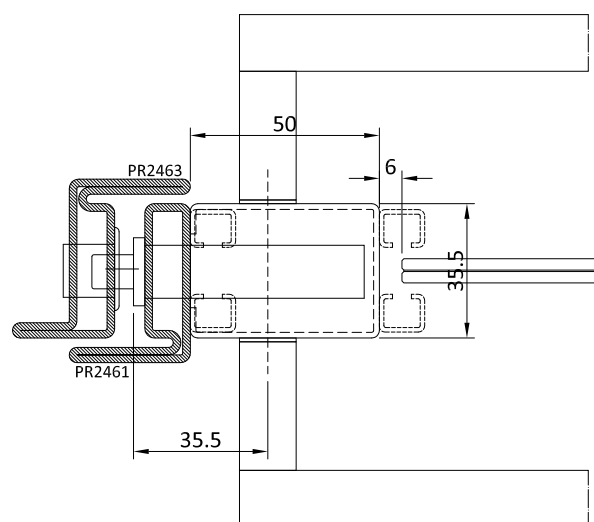
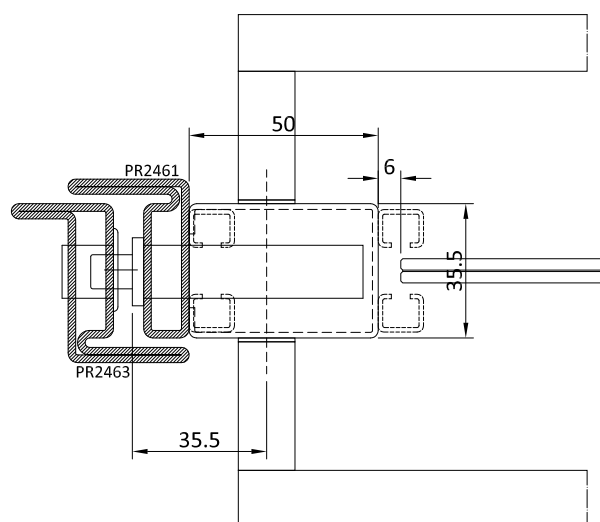
1

3

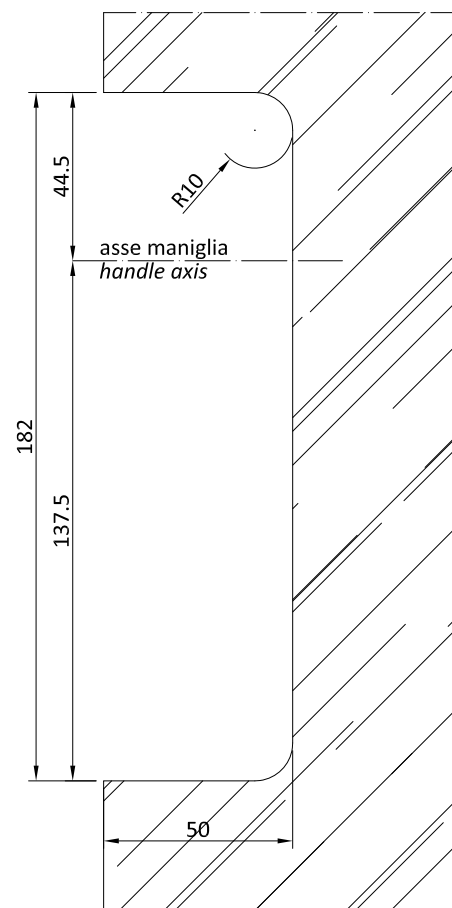
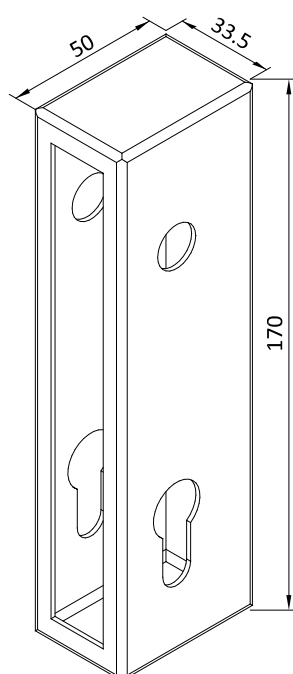
Prima di saldare i componenti scatola copri serratura, inserire la serratura e allineare i fori maniglia e cilindro alla scatola.

Before welding the lock box components, insert the lock and align the handle and cylinder holes to the lock box.





schema lavorazione vetro per inserimento serratura
glass processing scheme for lock insertion

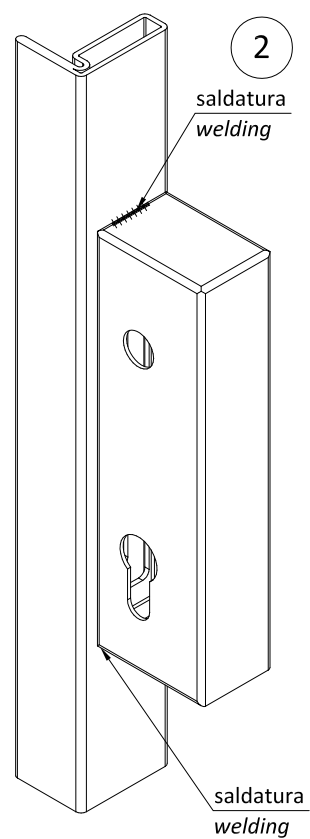
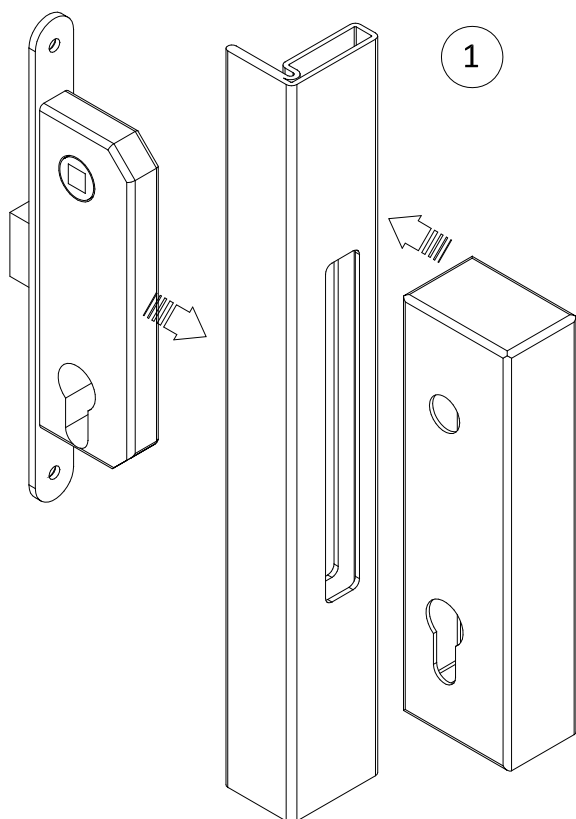
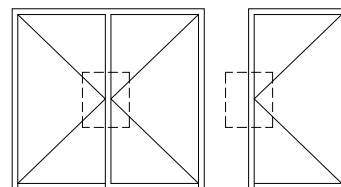


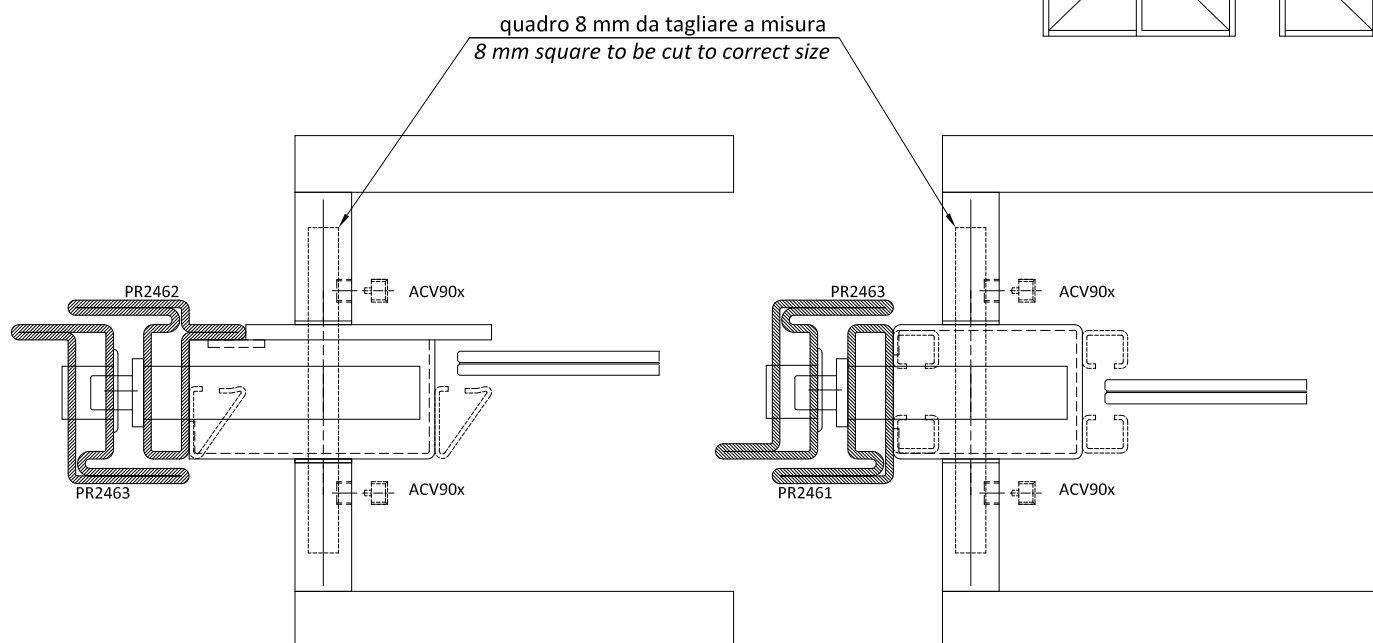
STEP

1

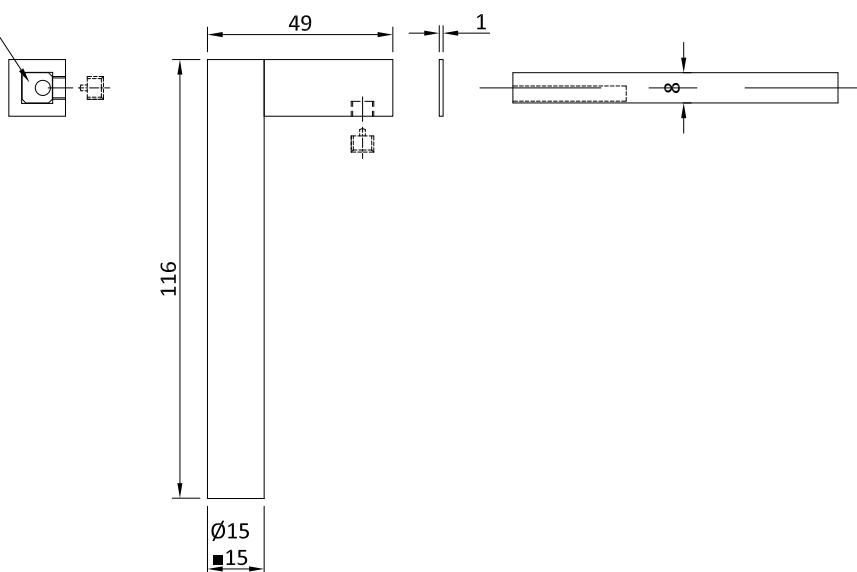
Prima di saldare la scatola copri serratura, inserire la serratura e allineare i fori maniglia e cilindro alla scatola.

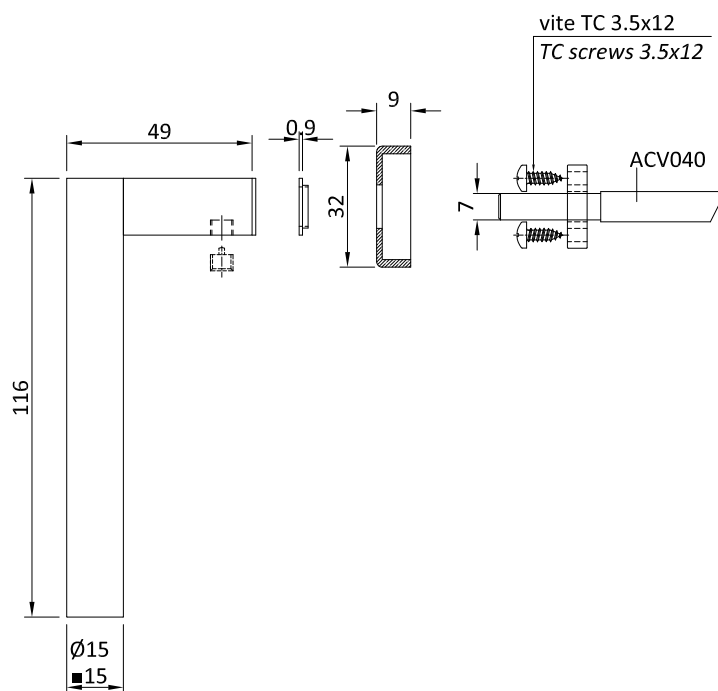
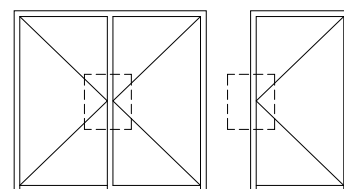
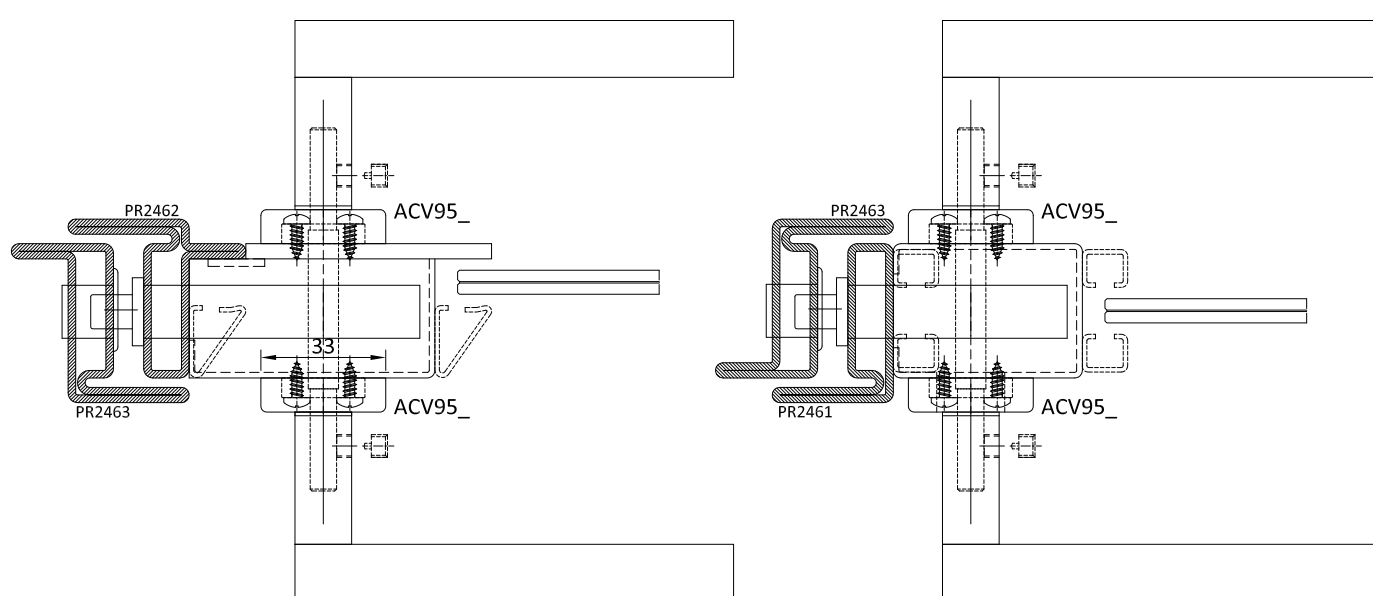
Before welding the lock box, insert the lock and align the handle and cylinder holes to the lock box.

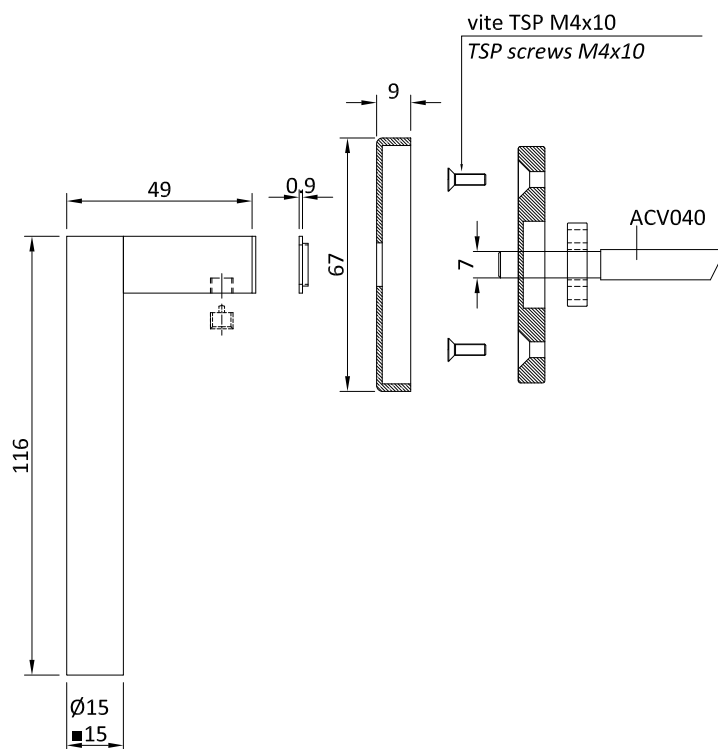
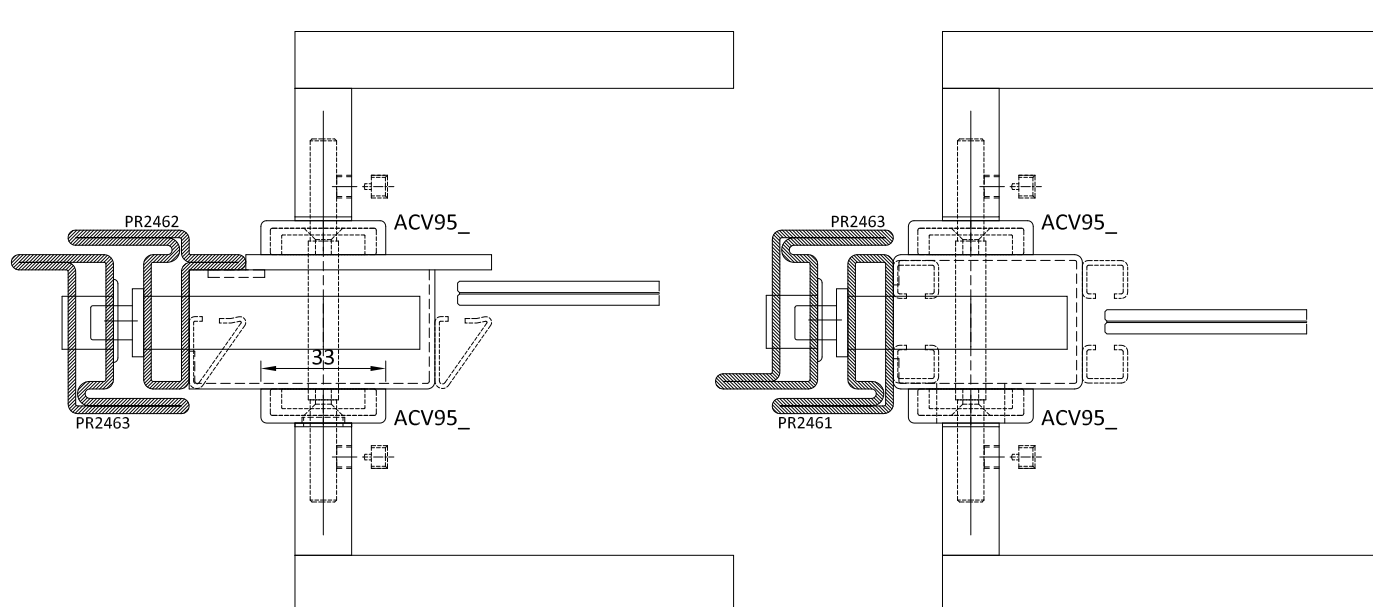


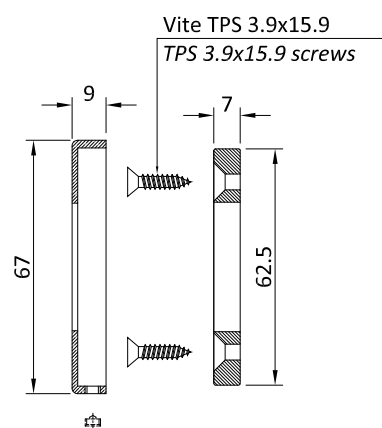
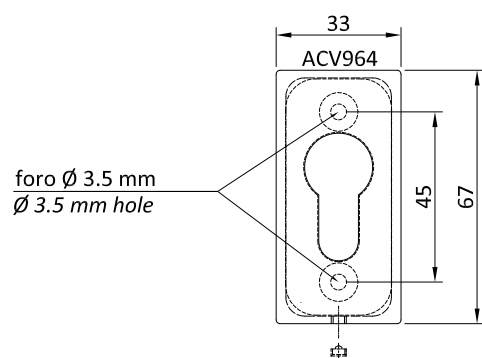
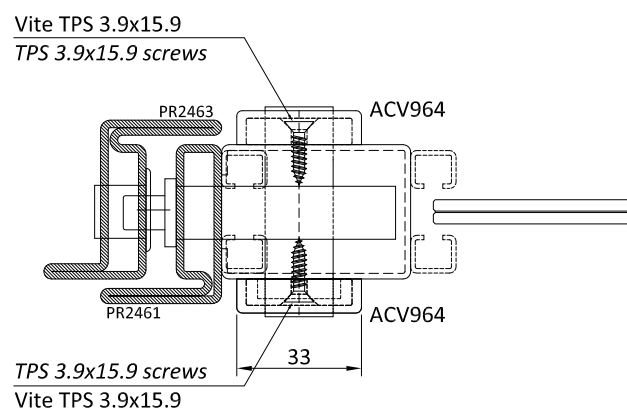
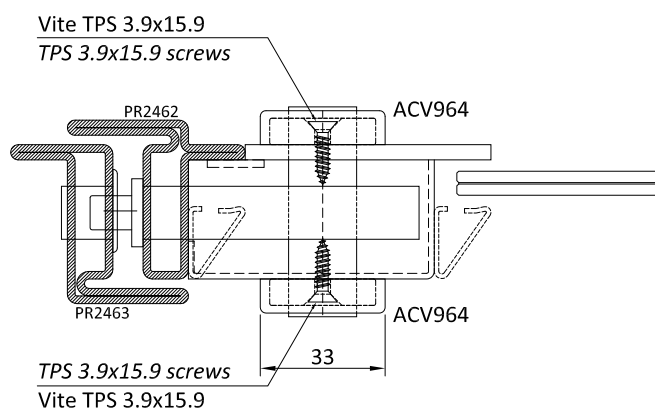
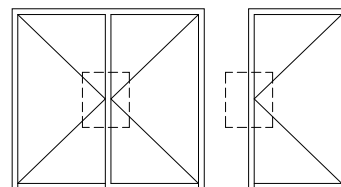


corretto inserimento quadro/grano
correct insertion of square/grain

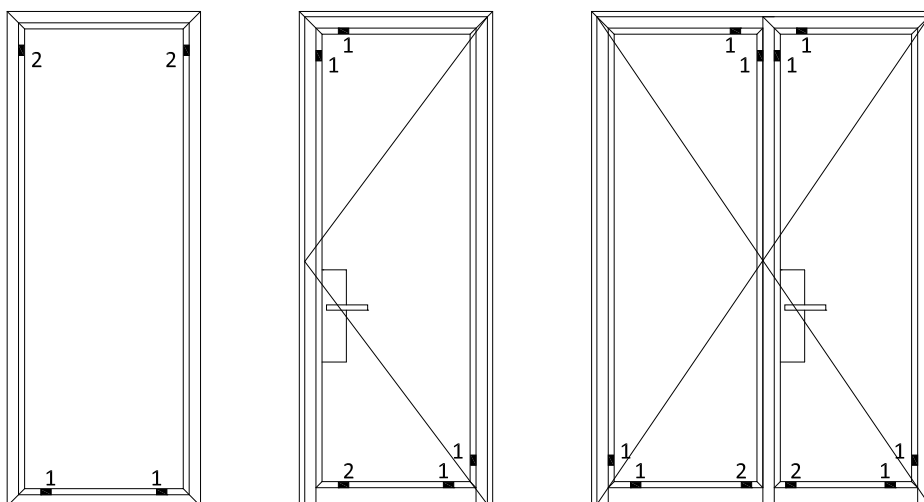




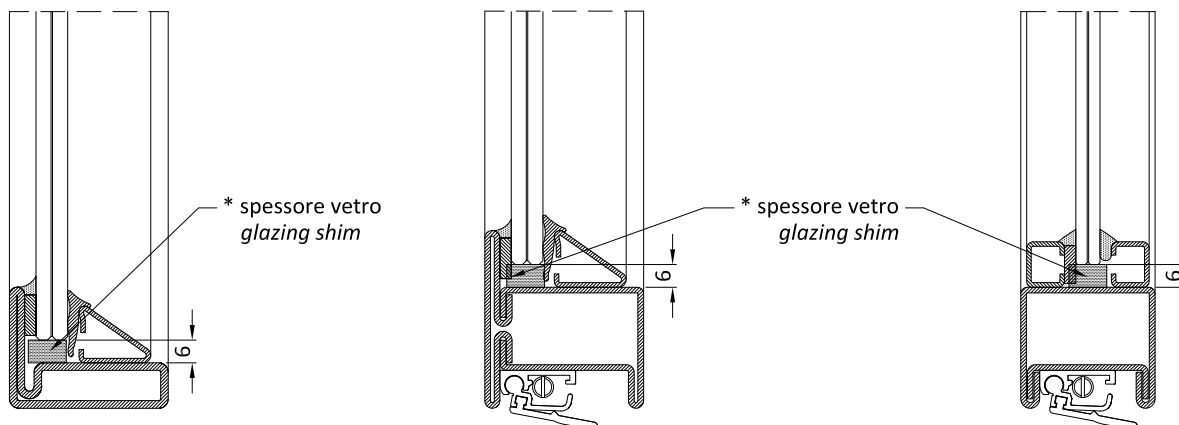




Porta | Door



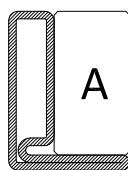
- 1) spessore portante | *carry shim*
 2) spessore distanziatore | *compensation shim*



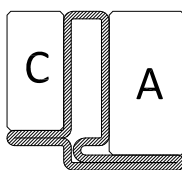
Note / Note

- La larghezza degli spessori è almeno pari o maggiore (+2 mm) dello spessore del vetro installato.
- The shims width is the same or bigger (+2 mm) than the installed glass spacer.
- La posizione degli spessori deve essere garantita dall'utilizzo di materiale adeguato che ne eviti la migrazione.
- The shims position has to be provided by using an appropriate material which avoids any movements.

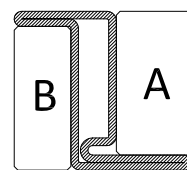
* spessori vetro non inclusi - *glazing shims not included*



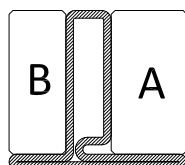
PR2461



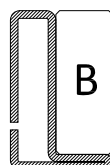
PR2462



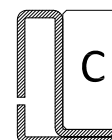
PR2463



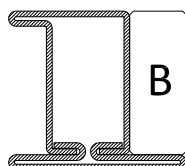
PR2482



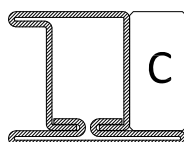
PR2451



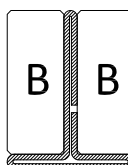
PR2471



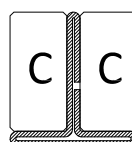
PR2455



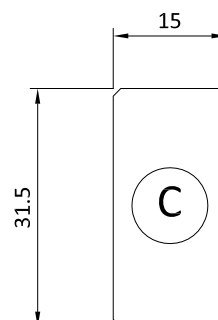
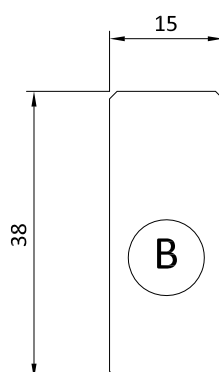
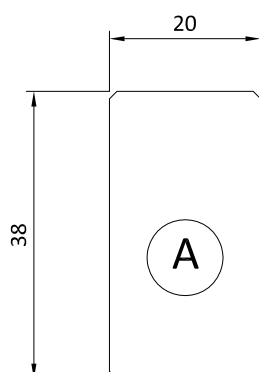
PR2474

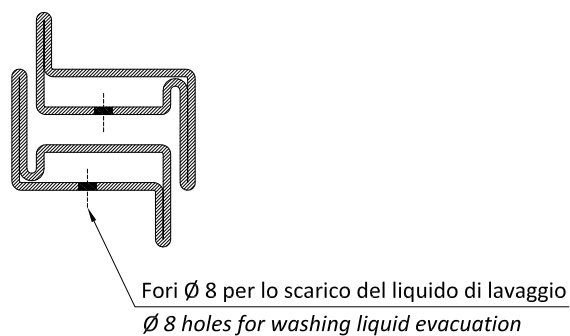
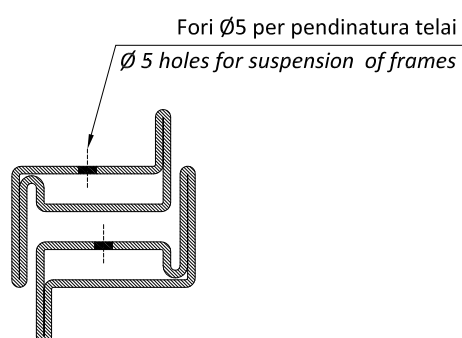
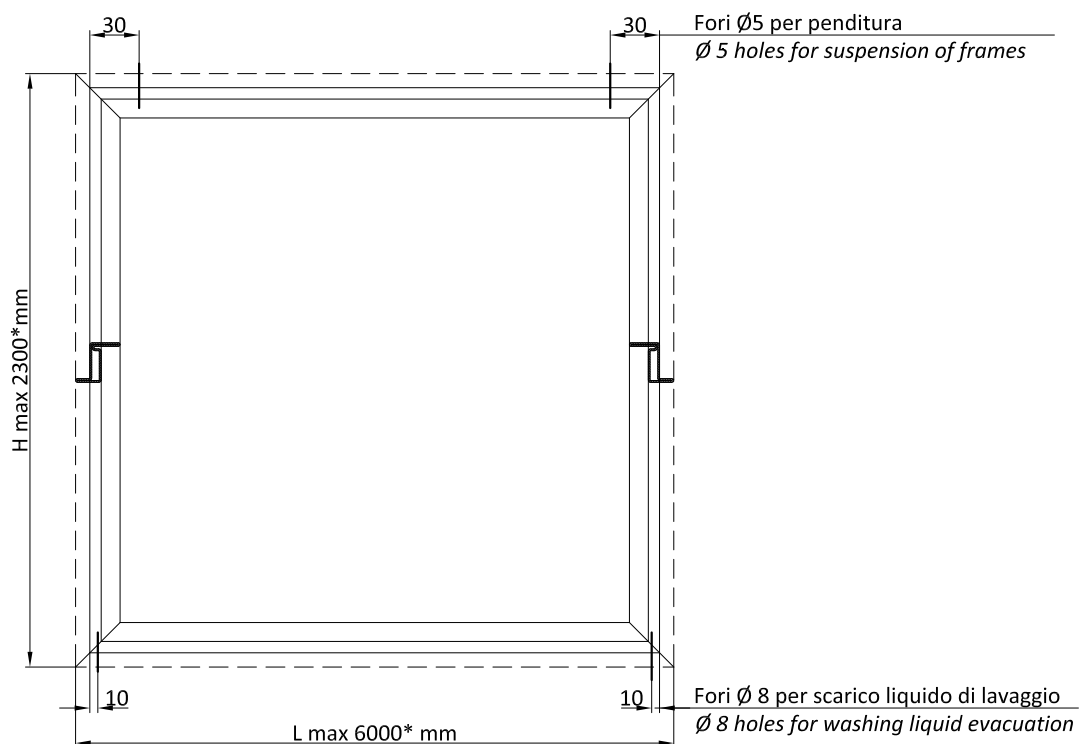


PR2454



PR2464





* Dimensioni massime da verificare con l'impianto di verniciatura scelto
Maximum dimensions to be checked with the chosen painting plant

Troncatricecaratteristiche minime della macchina

- Potenza: 1.8 – 2.5 kW;
- Possibilità di taglio a 45° nei due sensi e a 90°;
- Velocità di taglio ideali: 60-90 giri/min per acciaio;
- Capacità di taglio: 150 x 80 mm a 90°;
100 mm taglio a 45°.

caratteristiche della lama

- Lama da 350 mm con spessore 2.5 mm;
- N° denti: - 300 per tagli a 45°;
- 350 per tagli a 90°;
- Materiale: HSS (verificare materiali di commercio con finiture che migliorano la durata delle lame).

Pantografocaratteristiche minime della macchina

- Mandrino con velocità regolabile 2000-11000 giri/min;
- Struttura in ghisa adatta al taglio acciaio;
- Testata pesante per limitare le vibrazioni;
- Chiusura del profilo da lavorare con morse.

caratteristiche minime delle frese

- Materiale: HSS (verificare materiali di commercio con finiture che migliorano la durata delle frese);
- Frese a 4 denti;
- Frese con diametro 5 mm per le lavorazioni di scasso.

CutterMinimum requirements for the use of the machine

- Power: 1.8 – 2.5 kW;
- Possibility of cutting at 45° in both directions and at 90°;
- Ideal cutting speed: 60-90 rpm for steel;
- Cutting capability: 150 x 80 mm at 90°;
100 mm cut at 45°.

Blade specifications

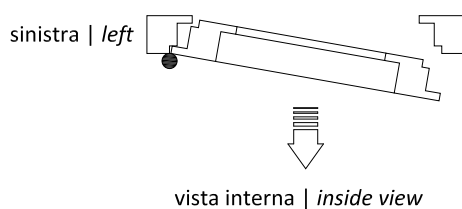
- 350 mm blade with a 2.5 mm thickness;
- Number of teeth: 300 for 45° cut;
350 for 90° cut;
- Material: HSS (please verify availability of longer lasting material on the market).

PhantographMinimum requirements for the use of the machine

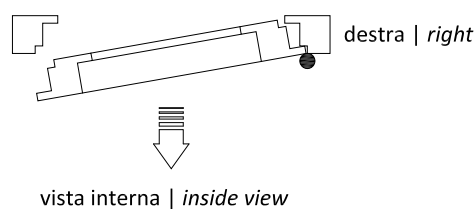
- Mandrel with a 2000-11000 rpm adjustable speed;
- Machine should be made of cast iron suitable for steel cutting;
- Heavy head in order to limit vibrations;
- Secure the profile to be processed in jaws.

Minimum requirements for the use of a milling machine

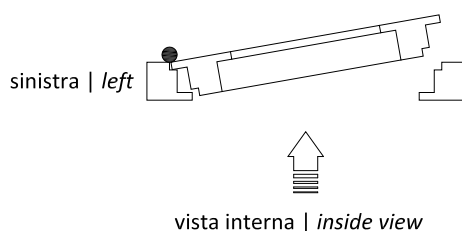
- Material: HSS (please verify availability of longer lasting material on the market);
- Use a 4-tooth milling machine;
- Use a milling machine with a 5-mm diameter for groove processing.

APERTURA INTERNA | INWARD OPENING

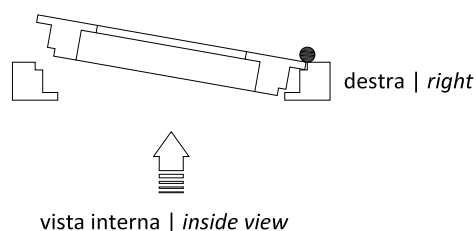
Codice Code	Profilo anta Leaf profile
Cerniere Hinges	
AC 2648	P.2463
AC 2649	P.2463
Serratura Lock	
AC 2493	P.2463
AC 2494	P.2463
Scatola serratura Lock cover box	
AC 2497	P.2463
AC 2498	P.2463



Codice Code	Profilo anta Leaf profile
Cerniere Hinges	
AC 2648	P.2463
AC 2650	P.2463
Serratura Lock	
AC 2493	P.2463
AC 2494	P.2463
Scatola serratura Lock cover box	
AC 2496	P.2463
AC 2498	P.2463

APERTURA ESTERNA | OUTWARD OPENING

Codice Code	Profilo anta Leaf profile
Cerniere Hinges	
AC 2648	P.2462
AC 2650	P.2462
Serratura Lock	
AC 2493	P.2462
AC 2494	P.2462
Scatola serratura Lock cover box	
AC 2497	P.2462
AC 2498	P.2462



Codice Code	Profilo anta Leaf profile
Cerniere Hinges	
AC 2648	P.2462
AC 2649	P.2462
Serratura Lock	
AC 2493	P.2462
AC 2494	P.2462
Scatola serratura Lock cover box	
AC 2496	P.2462
AC 2498	P.2462

1. Controllo materiale in arrivo / *Incoming equipment Control*Verifica visiva dell'intergrità delle barre con attenzione a: / *Profiles wholeness visual control paying attention to:*

- Strisci profondi / *Deep scratches* verifica visiva / *visual control*
- Botte e avvallamenti sulla superficie / *Bumps and dips on surface* verifica visiva / *visual control*
- Rettilineità barre / *Profiles straightness tolerance* 0,002 x L
- Svergolamento / *Profiles twist tolerance* 1° x m

2. Taglio barre e controllo barre / *Cut and Control of profiles*

- Misura lunghezza / *Length measurement* ±0.5 mm
- Verifica 45° / *45° Control* ± 1°
- Verifica 90° / *90° Control* ± 1°

3. Lavorazioni su barra / *Section processing*

Porta / Door	Aperture interne / Inward opening		Aperture esterne / Outward opening	
Fori per cerniere a tre ali <i>Three-wing hinge holes</i>	AC2648 sez 4.3.7		AC2648 sez 4.2.9	
Foratura per cerniera a due ali <i>Two-wing hinge holes</i>	AC2649/50 sez 4.2.6		AC2649/50 sez 4.2.8	
Fori e asole per serratura e incontri <i>Lock and strike slots and holes</i>	AC2493 sez 4.2.15	AC2494 sez 4.2.16	AC2493 sez 4.2.15	AC2494 sez 4.2.17
Taglio punta per inversione battuta <i>Secondary leaf top central joint working</i>	AC2653 sez 4.2.3-4		AC2653 sez 4.2.3-4	
Fori inserimento rinforzi cerniere <i>Hinge reinforcement holes</i>	- sez 4.3.1		- sez 4.3.2	
Fresatura per catenacci 2° anta <i>Secondary leaf flush bolt milling</i>	AC2440 sez 4.2.11-12	AC2621GB/GC sez 4.2.10	AC2440 sez 4.2.11-12	AC2621GB/GC sez 4.2.10
Fori fissaggio a muro <i>Wall mounting holes</i>	sez 3.2.1-2		sez 3.2.1-2	

4. Assiemaggio / *Assembly*

Porta / Door	Aperture interne / Inward opening	Aperture esterne / Outward opening
<u>Costruzione telai / Frame assembly</u>		
Saldatura / Welding	- sez 4.3.1-3	- sez 4.3.1-3
Taglio punta per inversione battuta Secondary leaf top central joint working	AC2653 sez 4.2.3-4	AC2653 sez 4.2.3-4
<u>Applicazione accessori / Accessories installation</u>		
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Fori per cerniere a tre ali Three-wing hinge holes	AC2648 sez 4.3.7	AC2648 sez 4.2.9
Foratura per cerniera a due ali Two-wing hinge holes	AC2649/50 sez 4.2.6	AC2649/50 sez 4.2.8
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Lavorazione per paraspiro automatico Automatic door bottom seal installation holes	AC2436 sez 4.2.13	AC2436 sez 4.2.14

5. Preparazione per verniciatura / *Preparation for the powder coating*

- | | |
|--|-----------|
| a. Fori su telaio per scarichi liquidi pretrattamento
<i>Holes on frame for the drainage of pretreatment liquid</i> | sez 5.1.4 |
| b. Marcatura e imballo telai esterni e ante
<i>External frames and leafs branding and packing</i> | - |
| c. Marcatura e imballo telai fermavetro
<i>Glazingbeads frames branding and packing</i> | - |
| d. Marcatura e imballo profili complementari
<i>Additional profiles branding and packing</i> | - |
| e. Imballo scarichi acqua e cerniere
<i>Accessories (water drip, hinges) branding and packing</i> | - |

6. Applicazione accessori / *Hardware and accessories installation*
 Porta / *Door*
 - I. Montaggio cerniere / *Hinges installation* sez 4.2.6-9
 - II. Montaggio serratura e incontri / *Lock and strikes installation* sez 4.2.15-17
 - III. Applicazione paraspiiffero automatico /
Automatic door bottom seal installation holes sez 4.2.13-14
 - IV. Montaggio catenaccio / *Flush bolt installation* sez. 4.2.10-11
 - V. Montaggio guarnizioni di battuta / *Gasket installation*
7. Vetrazione / *Glazing*
 - a. Applicazione clips fermavetro / *glazing bead clips installation* sez 2.6.1-7
 - b. Applicazione guarnizione esterna / *External glazing gasket installation*
 - c. Applicazione vetro (spessoramento) / *Glazing installation (setting blocks)* sez 4.5.1
 - d. Inserimento fermavetri / *Glazing beads application*
 - e. Inserimento guarnizione interna fermavetro / *Fit glazing bead to glass gasket*
 - f. Verifica corretta compressione guarnizione / *Control of the right compression of the gasket*
8. Controlli su prodotto finito / *Control on finished element*
 - a. Verifica distanza tra anta e telaio / *Control of gap between leaf and frame* +0 +0.5 mm
 - b. Verifica sormonto anta su telaio / *Control of leaf surmount* +0 +1 mm
 - c. Verifica funzionamento maniglia serratura / *Control of hardware functioning*
 - d. Verifica finitura superficiale / *Control of surface finishing*
9. Controlli dopo la posa / *Controls after installation*
 - a. Verifica corretta installazione telai: squadra, piombo, misure /
Control of alignment and plumb of frame and leaf
 Verifica distanza tra anta e telaio / *Control of gap between leaf and frame* +0 +0.5 mm
 - b. Verifica sormonto anta su telaio / *Control of leaf surmount* +0 +1 mm
 Verifica funzionamento maniglia serratura / *Control of hardware functioning*
 - c. Verifica finitura superficiale / *Control of surface finishing*

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